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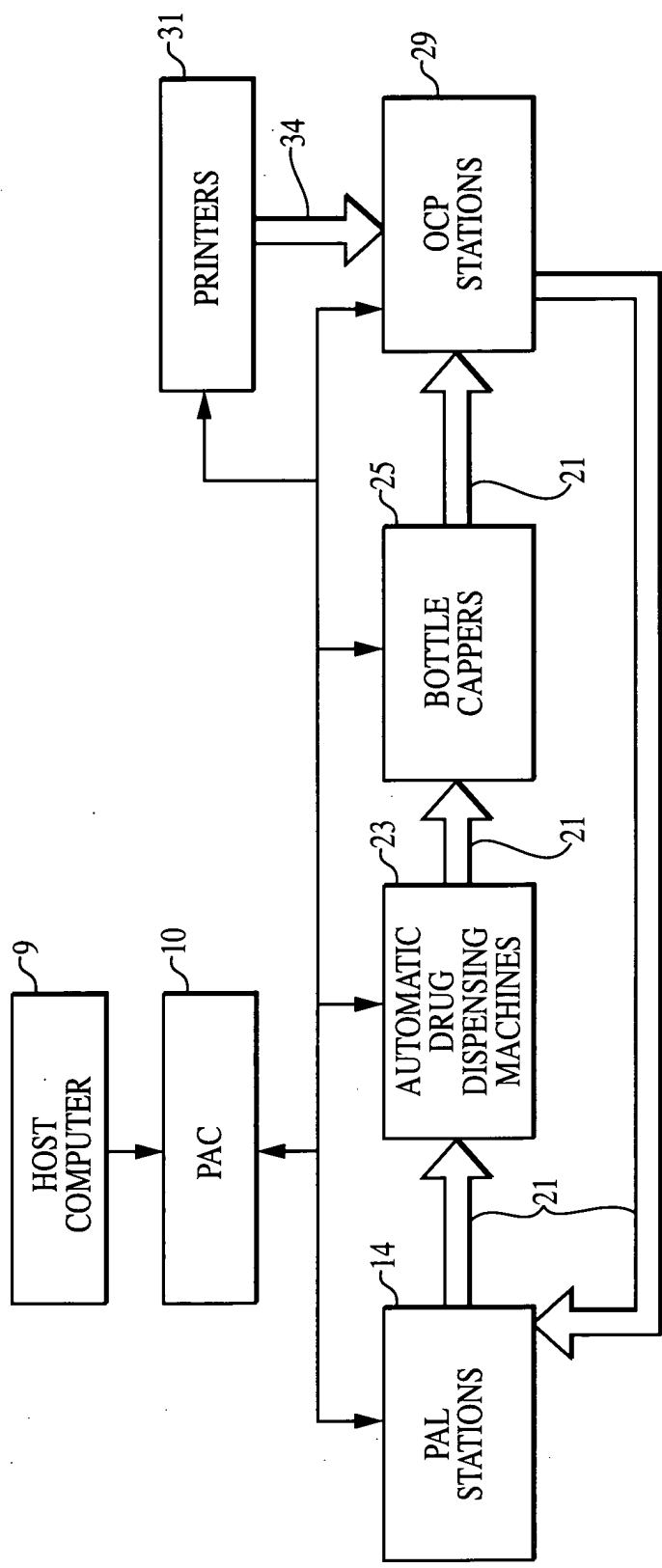


FIG. 1A

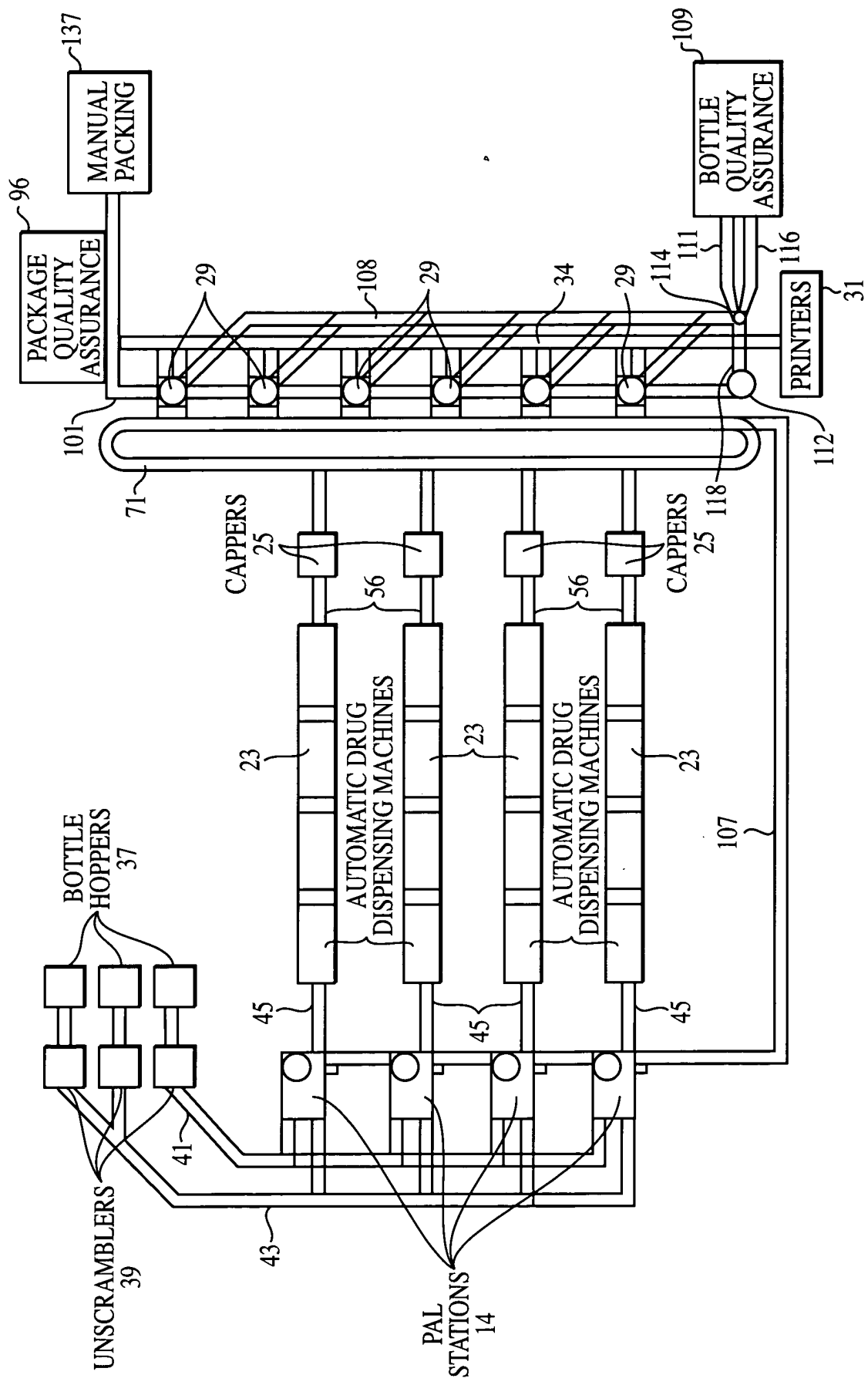


FIG. 1B

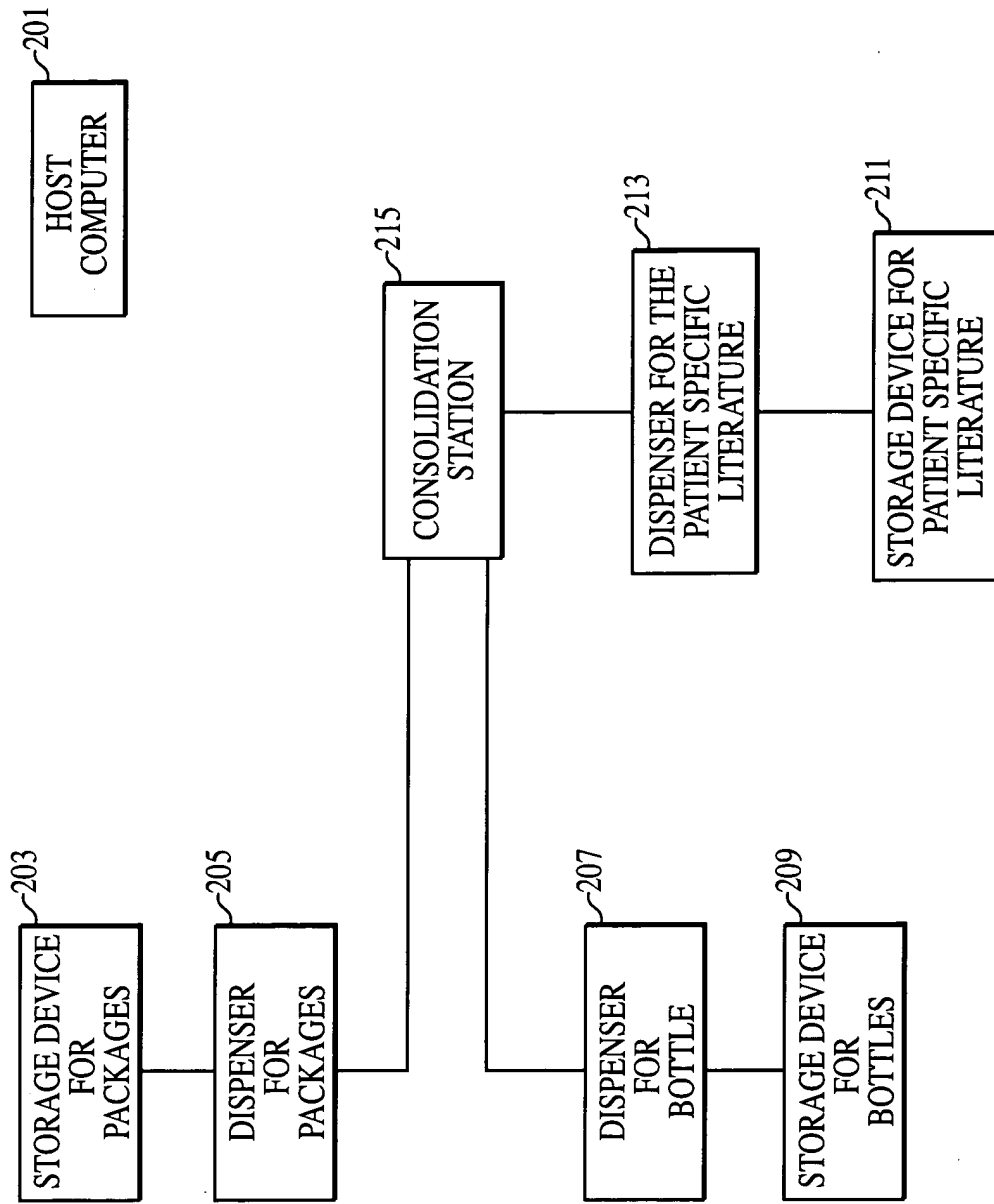


FIG. 2

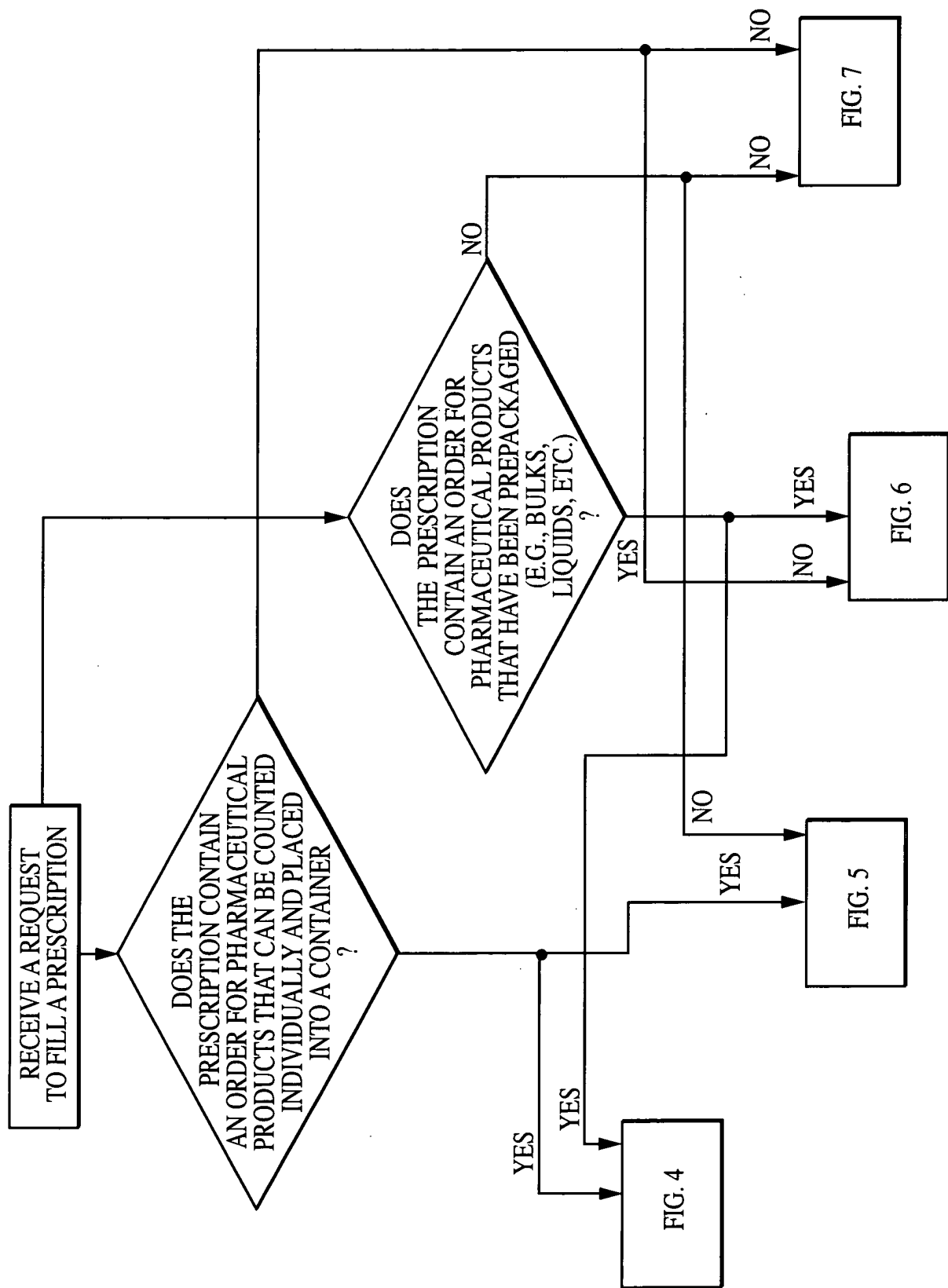


FIG. 3

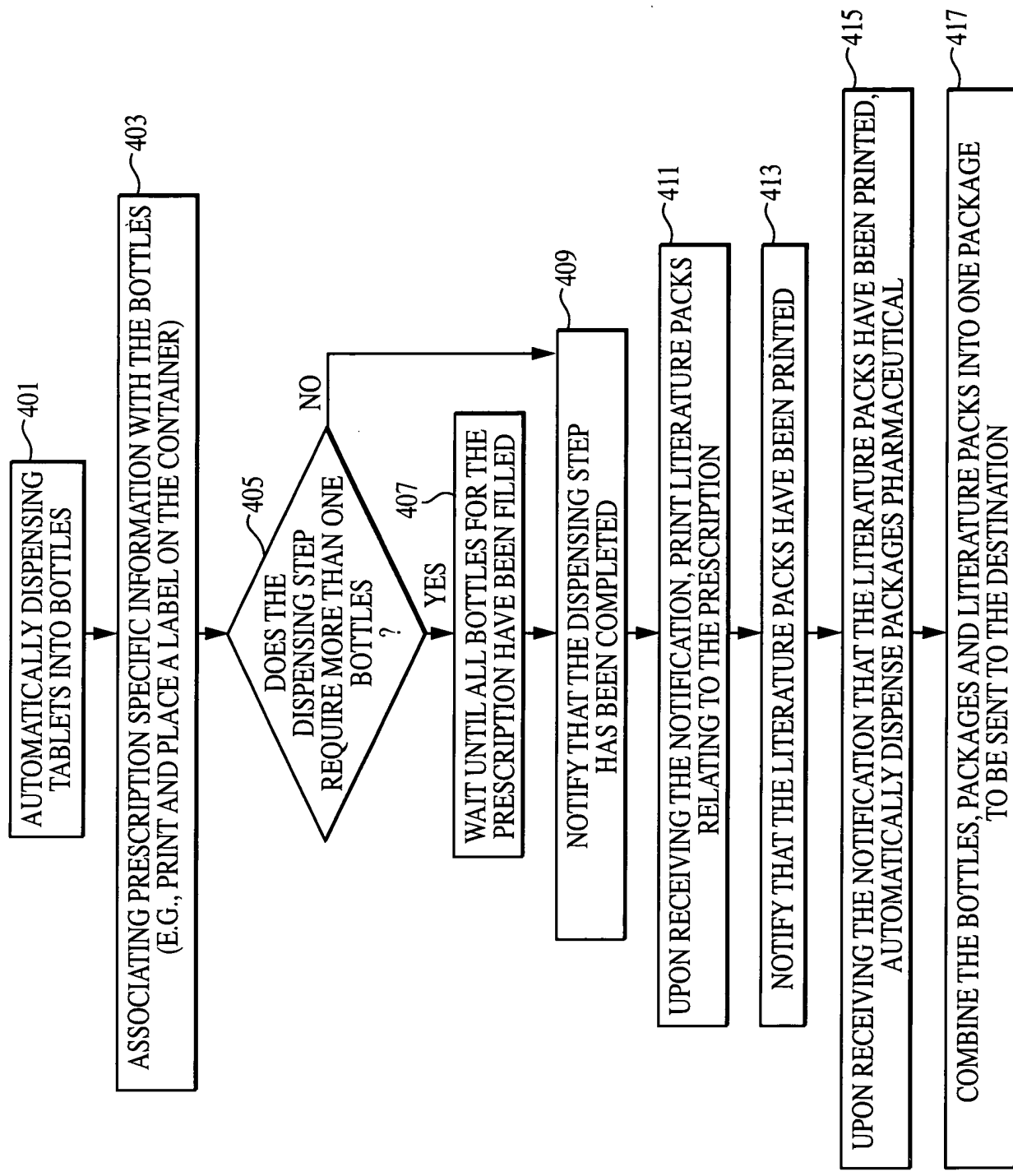


FIG. 4

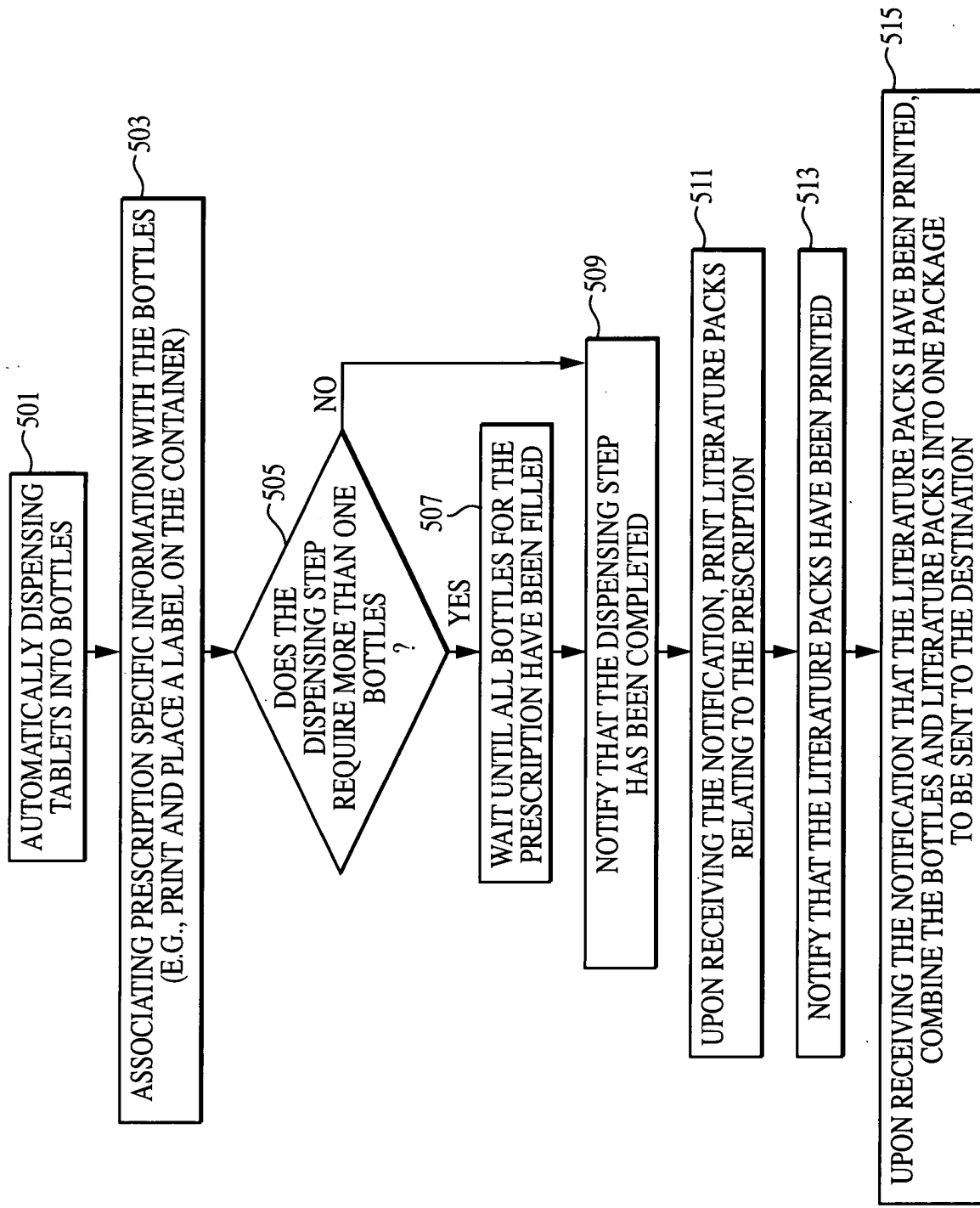


FIG. 5

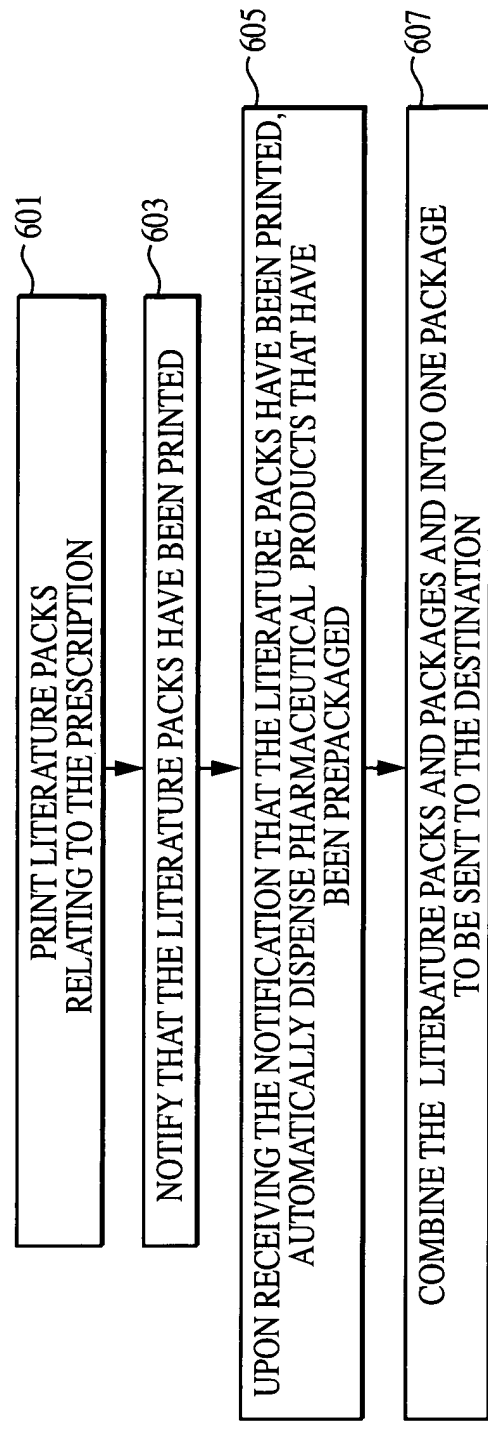


FIG. 6

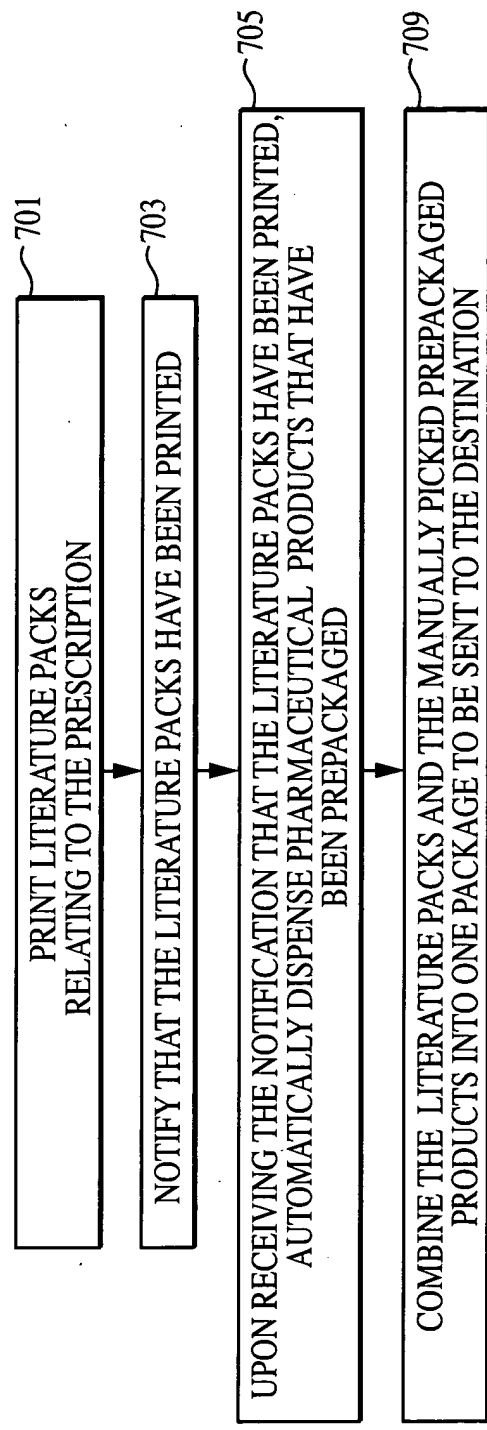
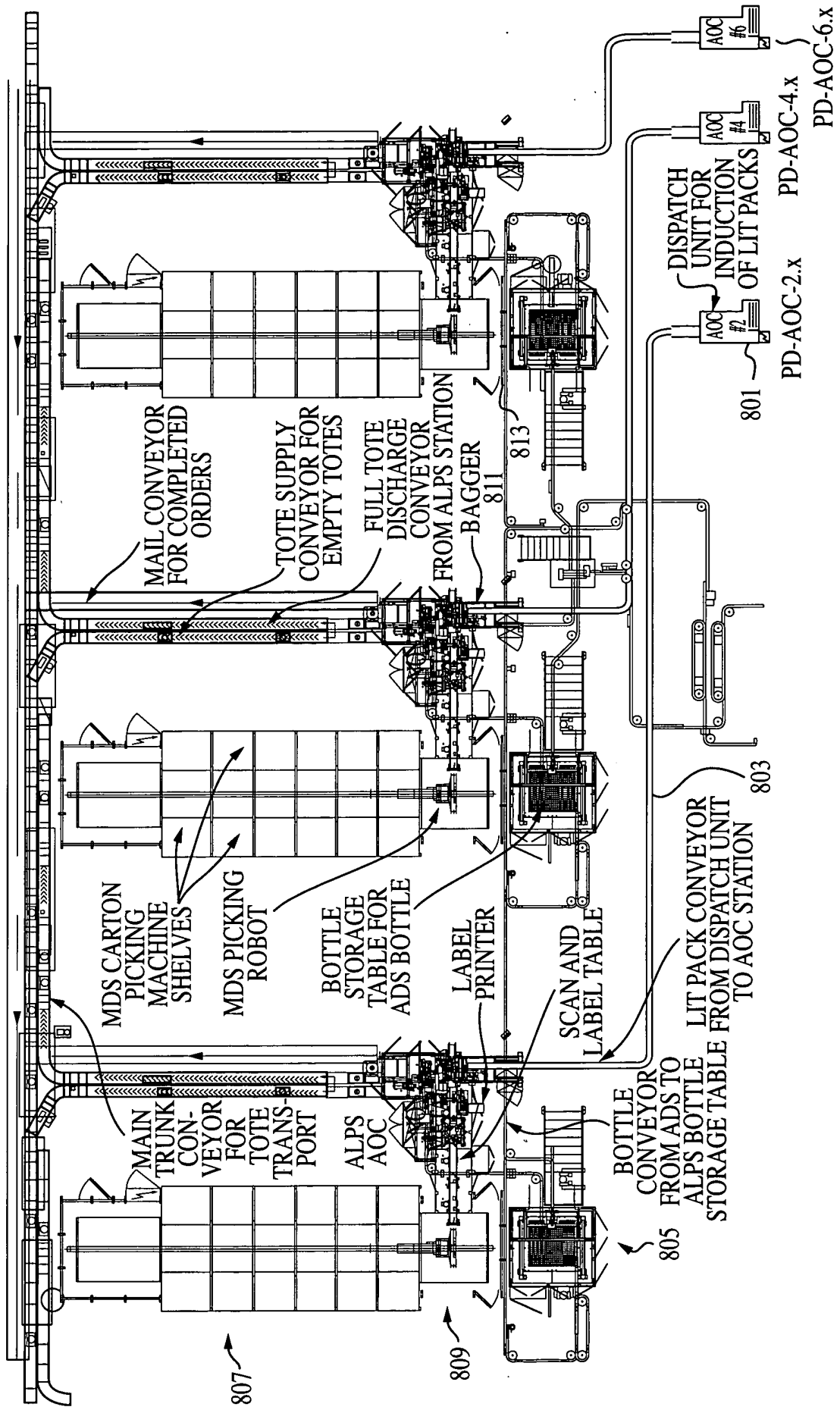
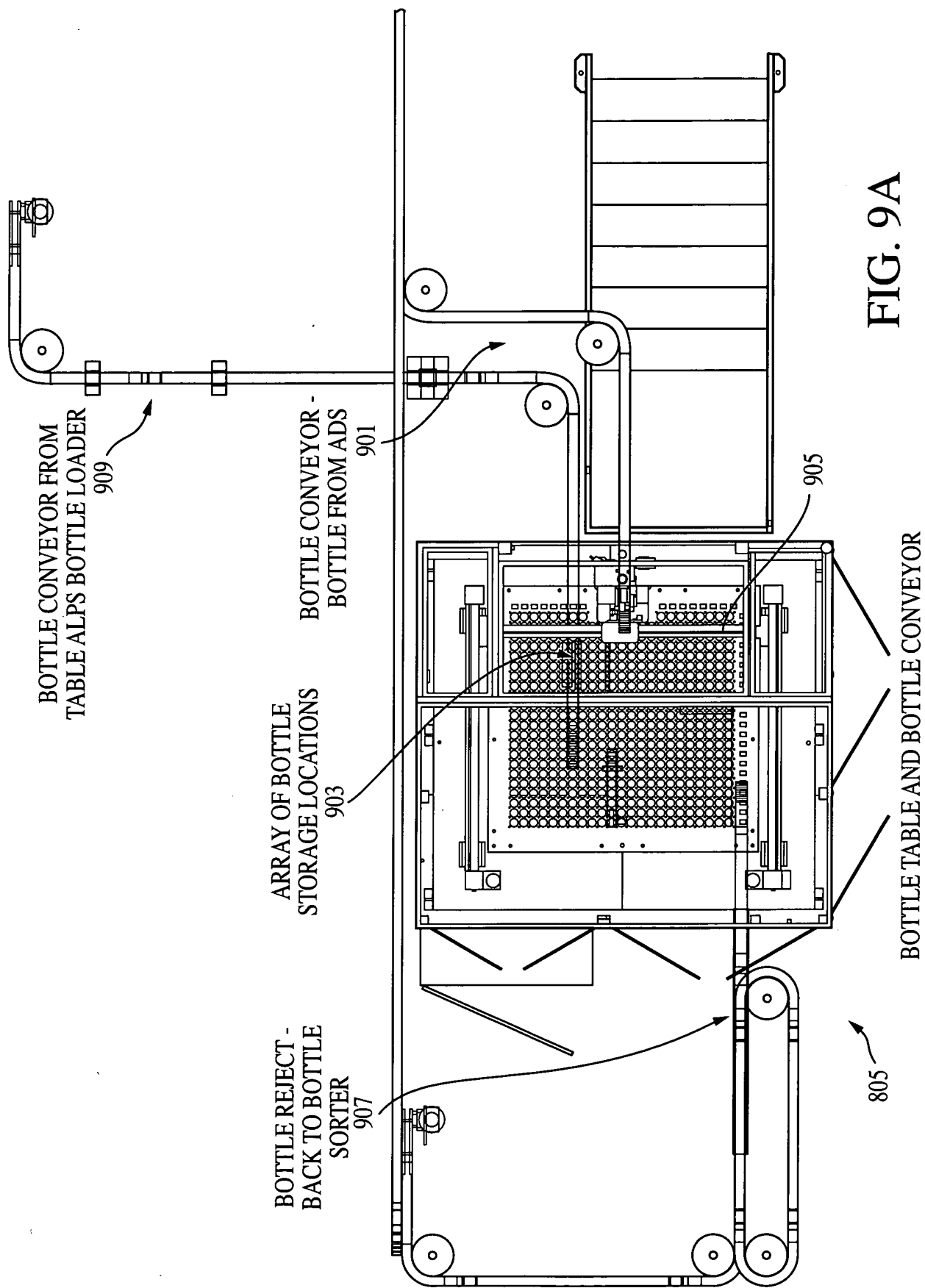


FIG. 7



ALPS OVERALL LAYOUT (3 ALPS SUBSYSTEMS)

FIG. 8



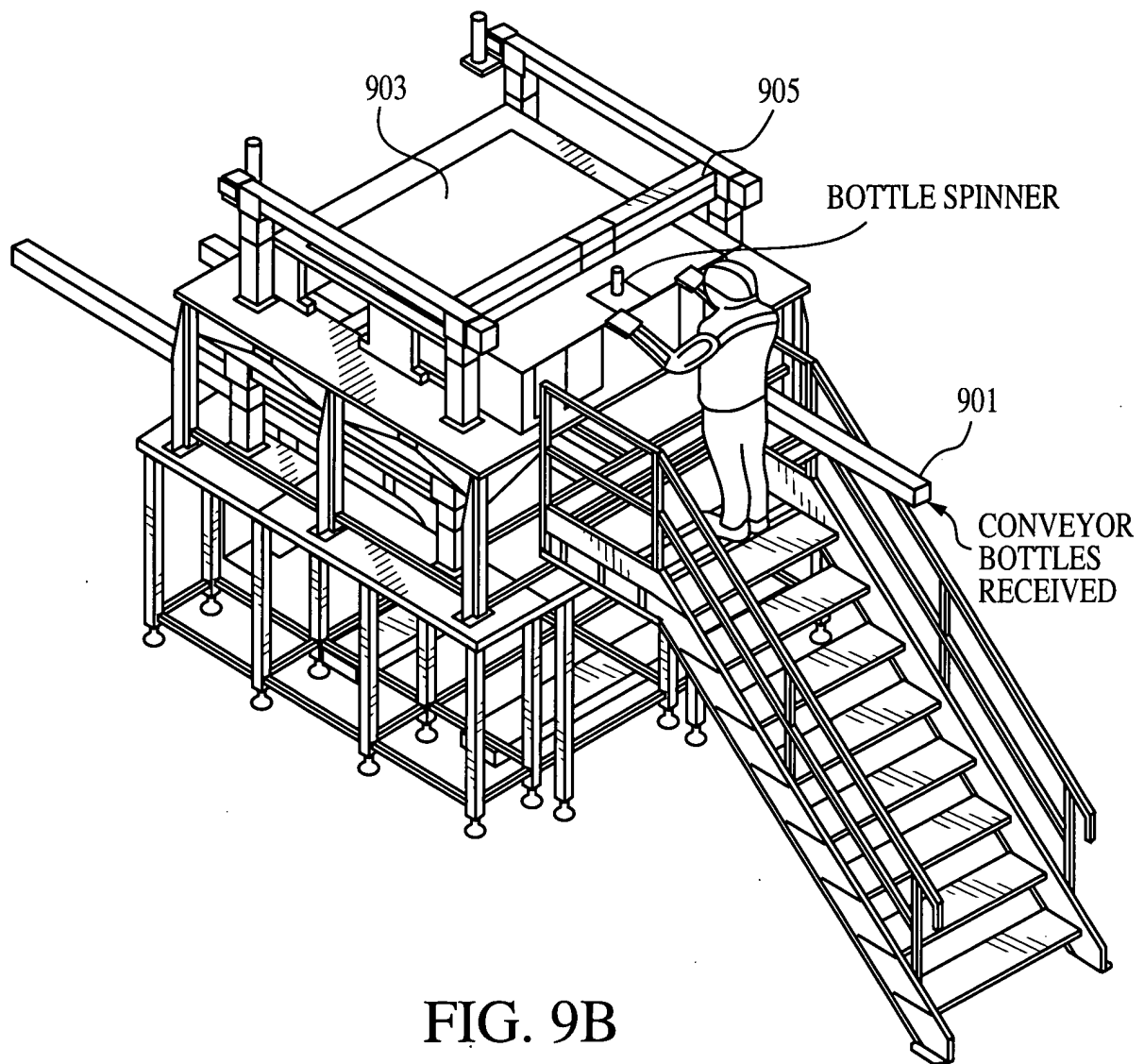


FIG. 9B

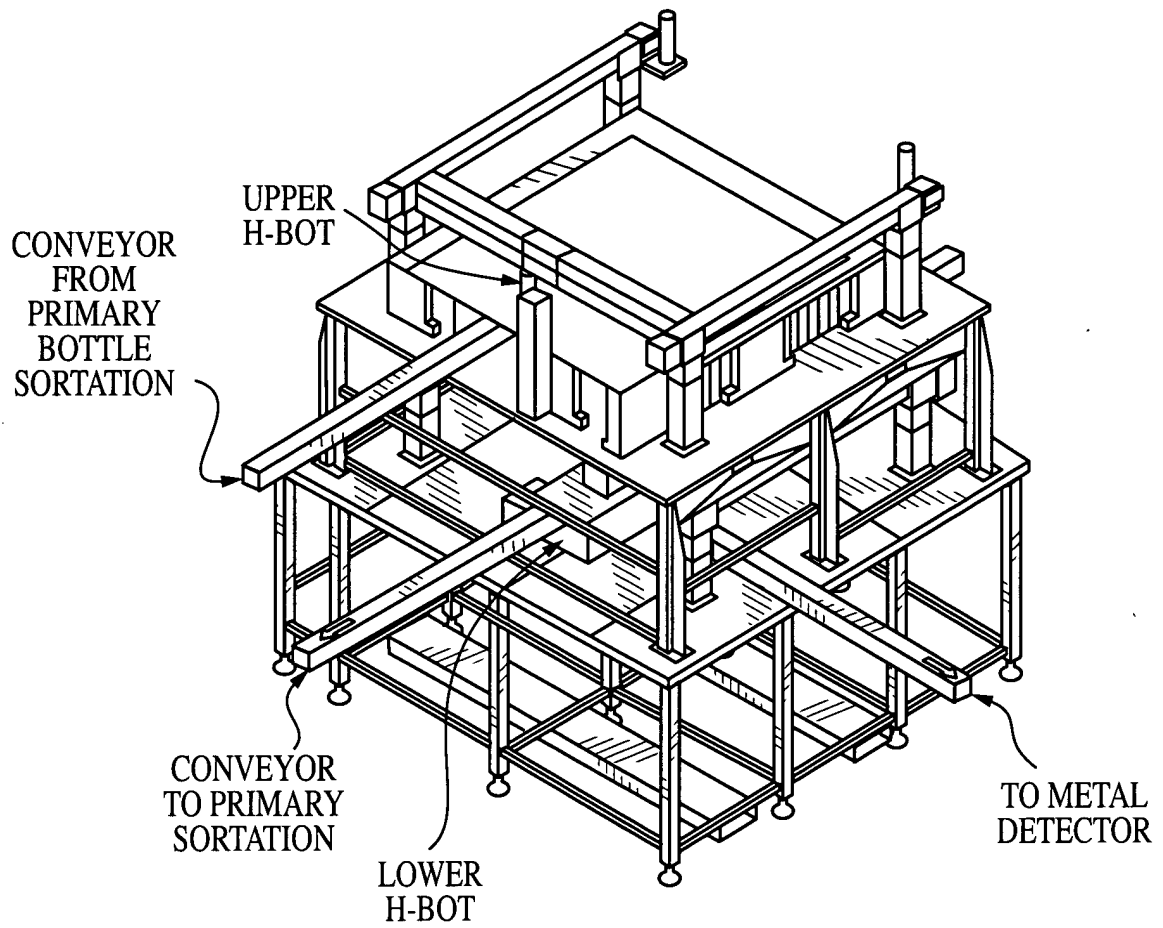


FIG. 9C

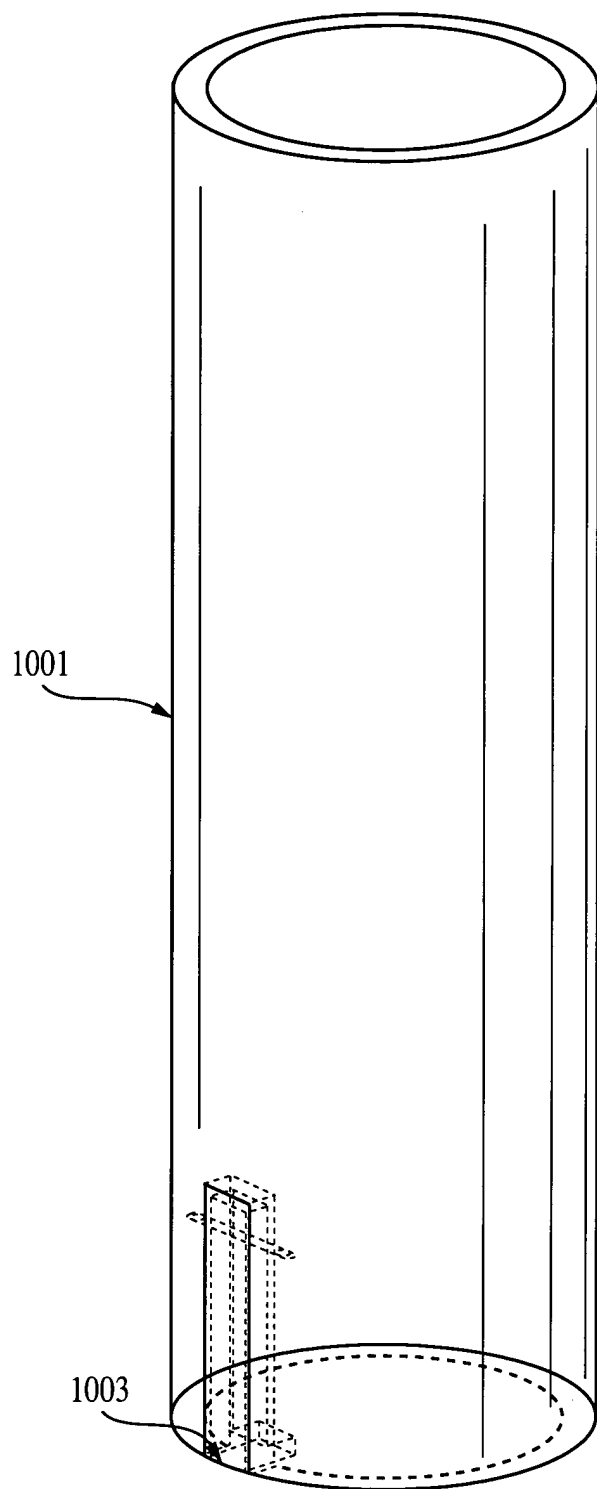
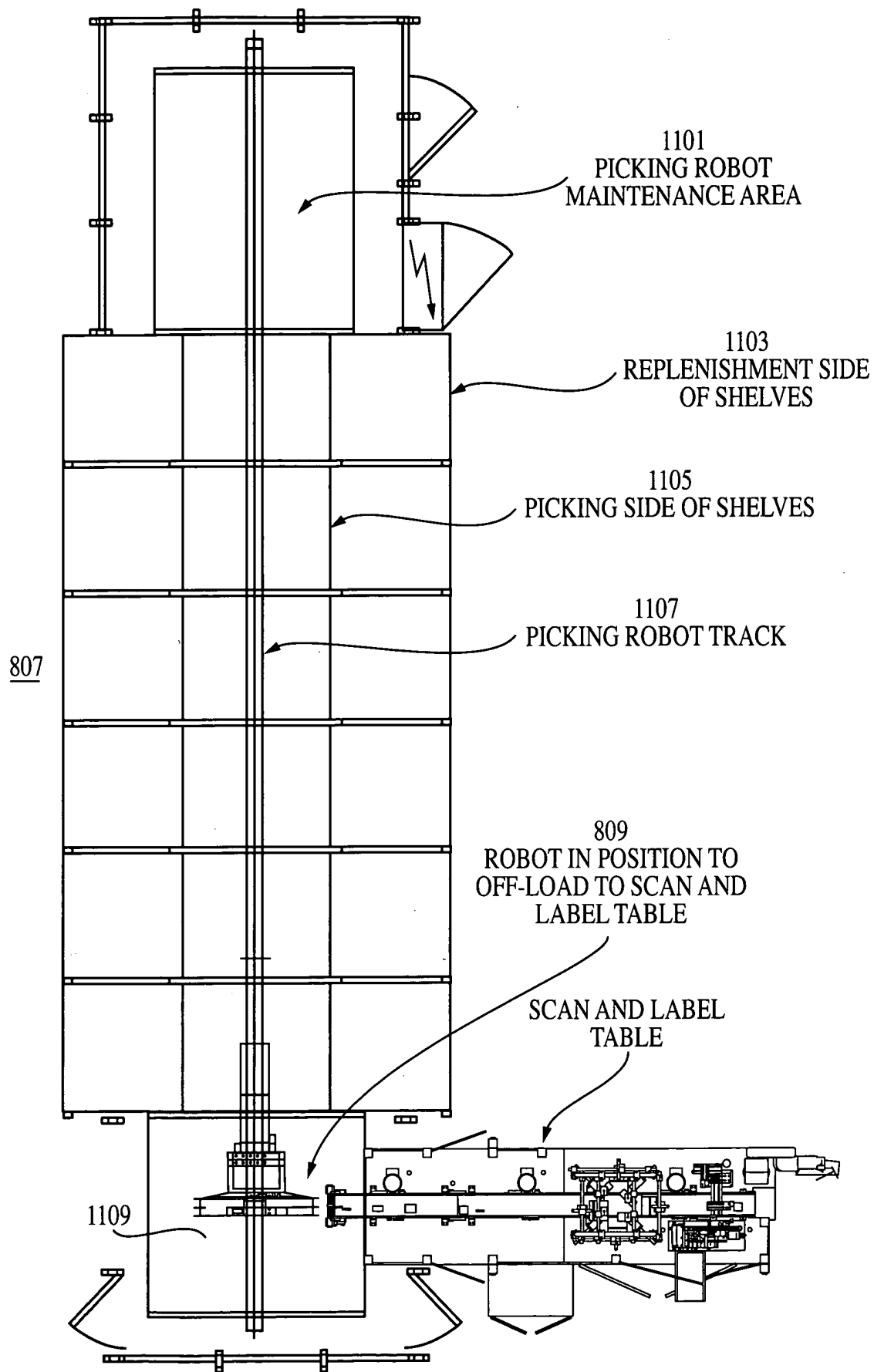


FIG. 10



SINGLUATE/SCAN TUNNEL/LABEL STATION

FIG. 11

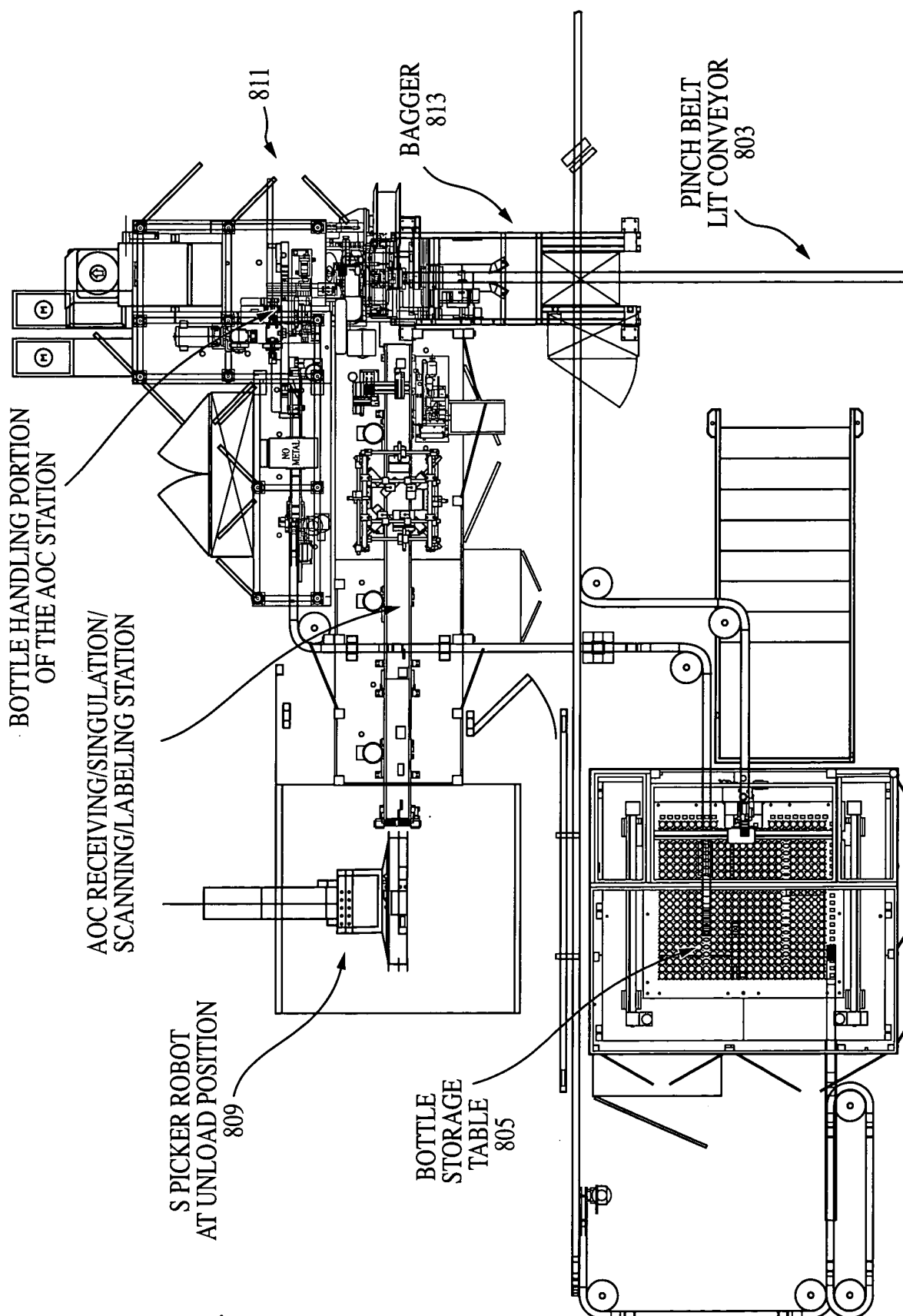


FIG. 12

CLOSE-UP OF AOC STATION (BOTTLE TABLE, MDS, AOC, BAGGER)

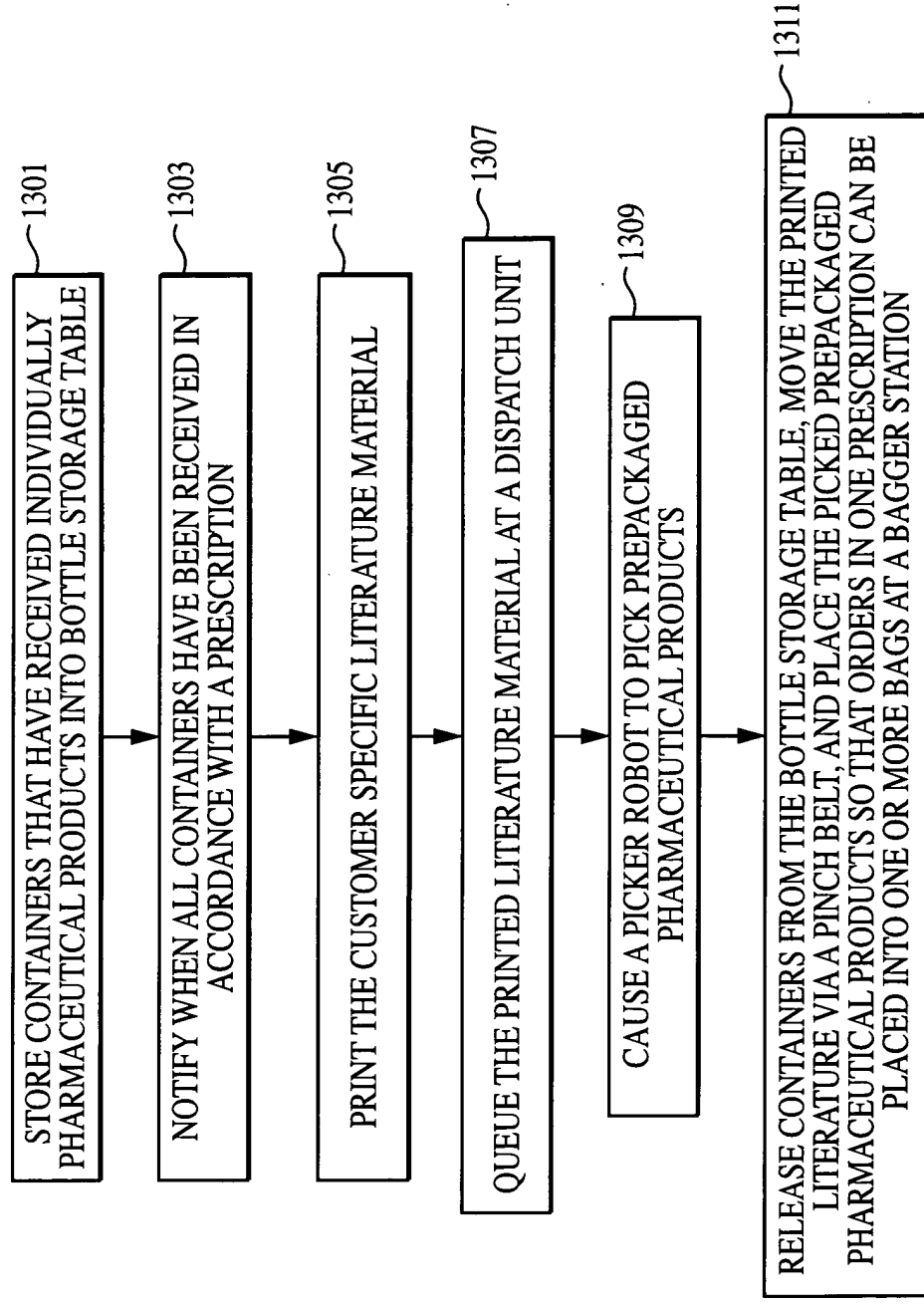


FIG. 13

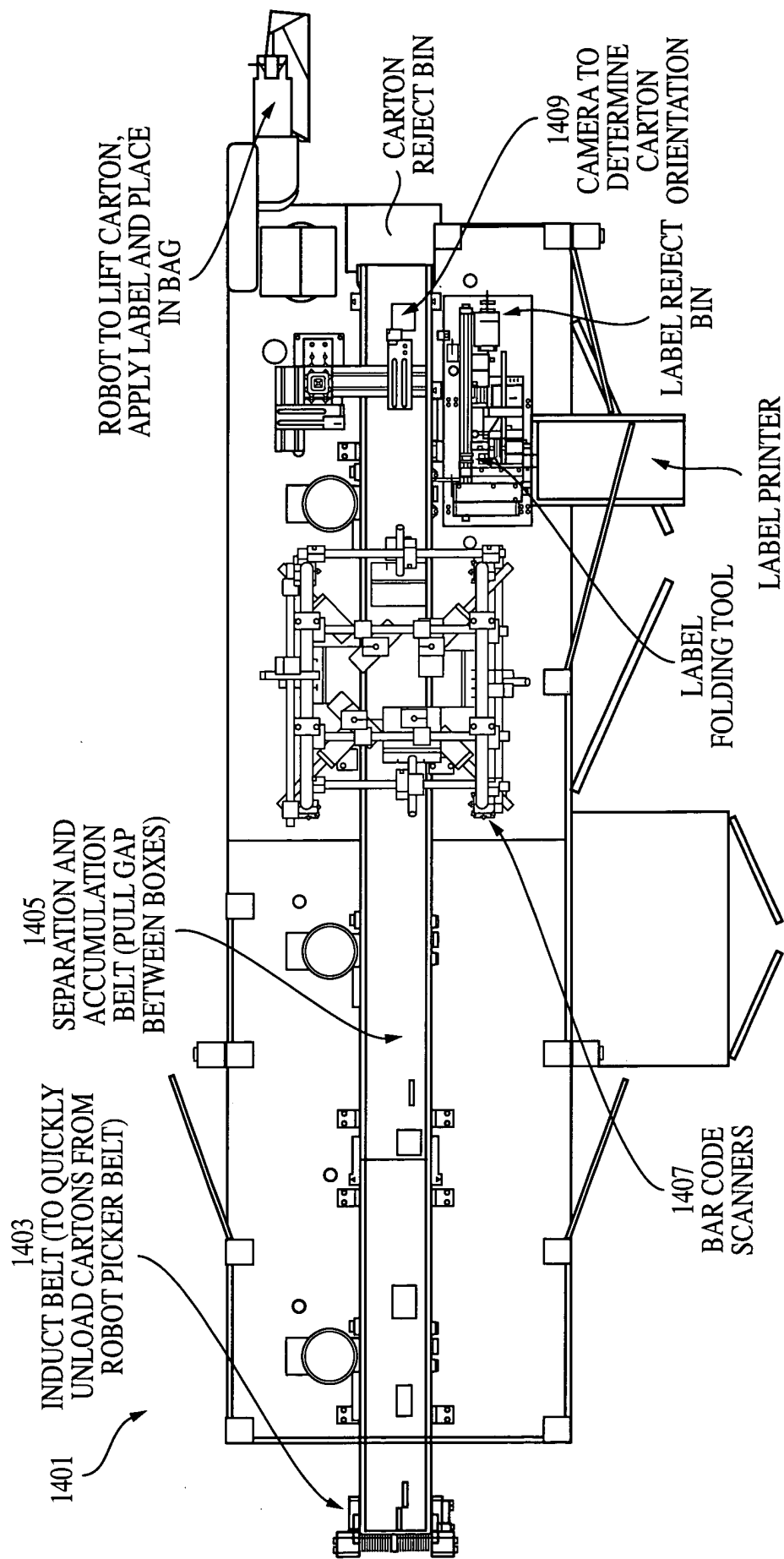


FIG. 14

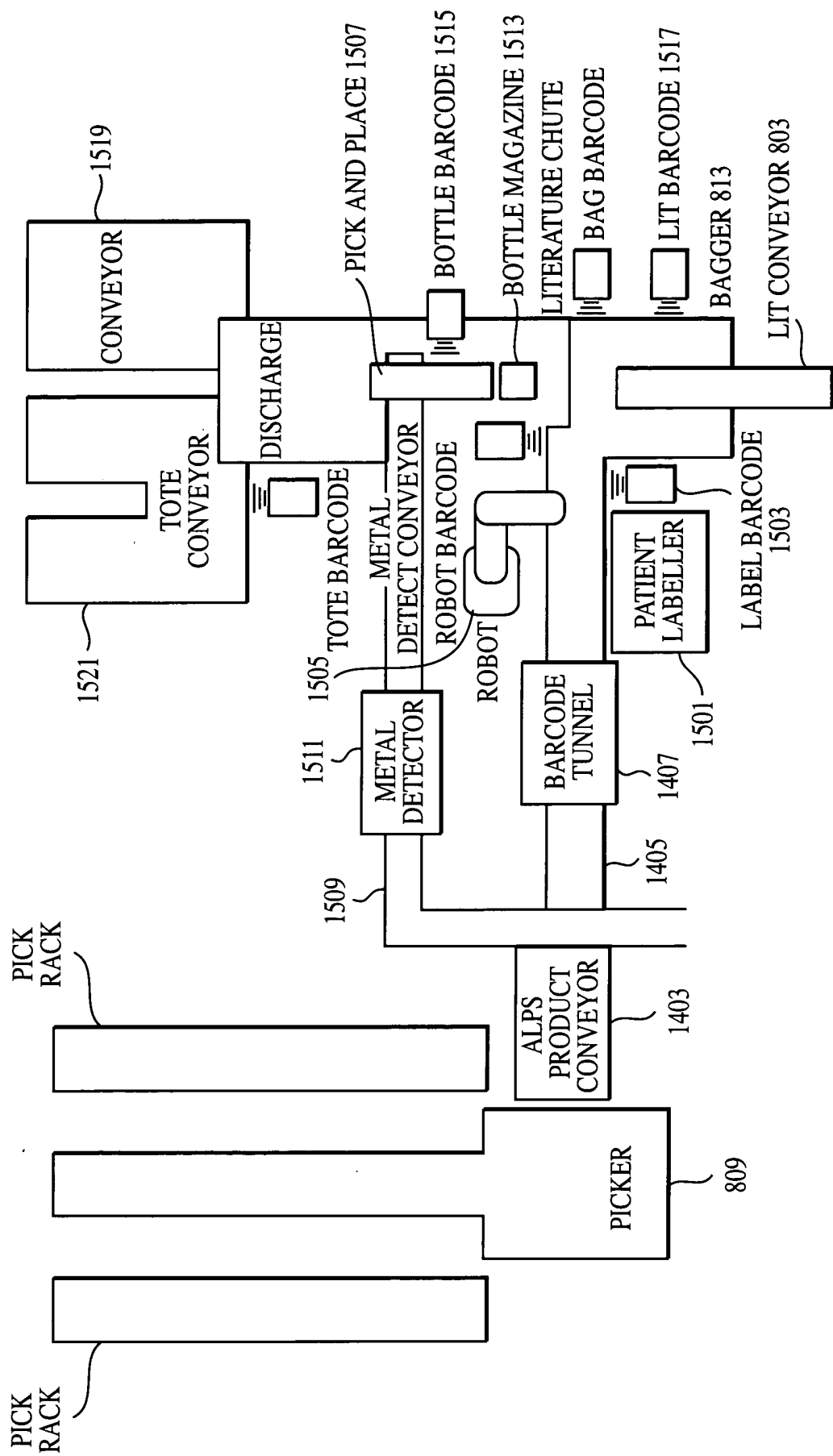


FIG. 15A

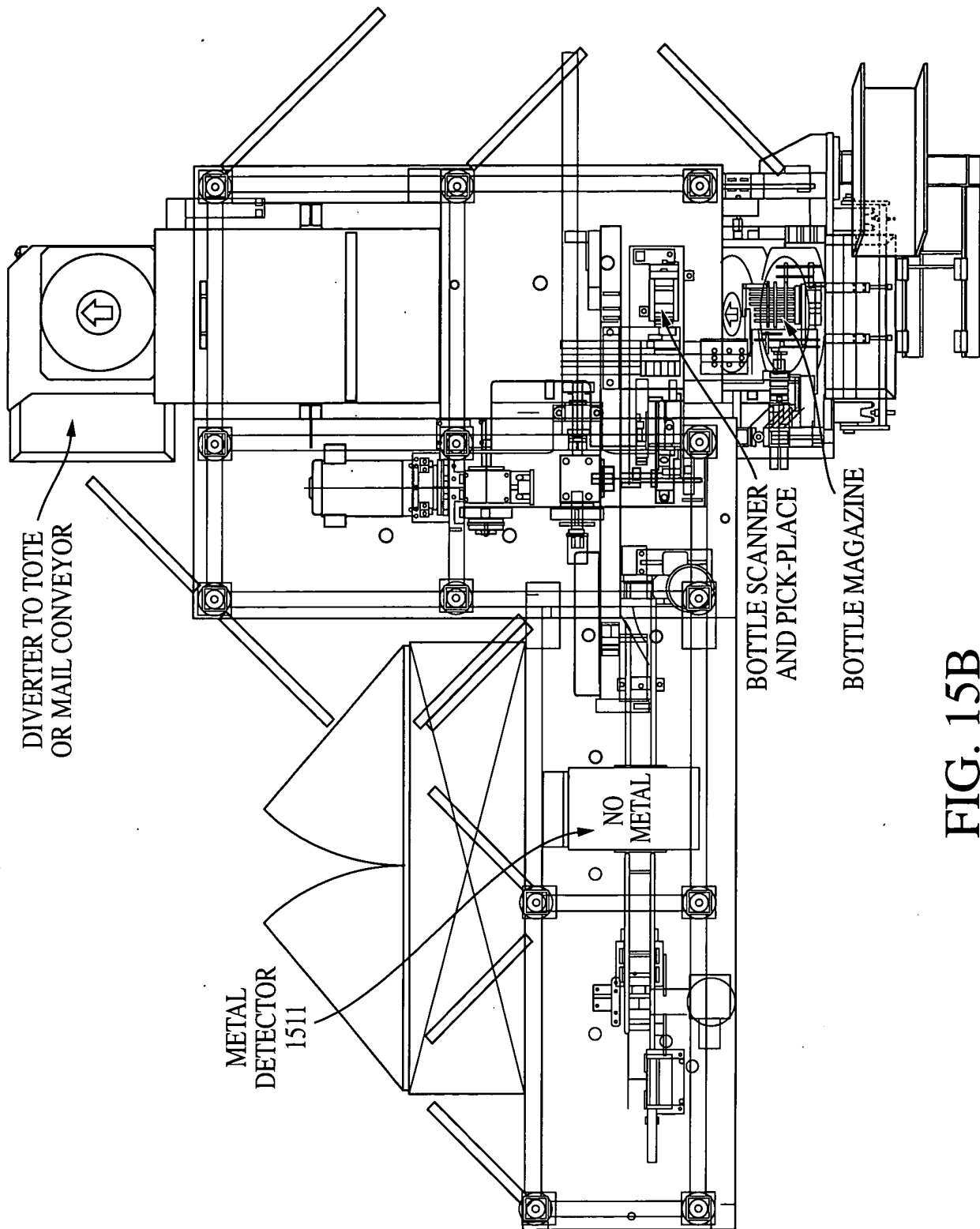


FIG. 15B

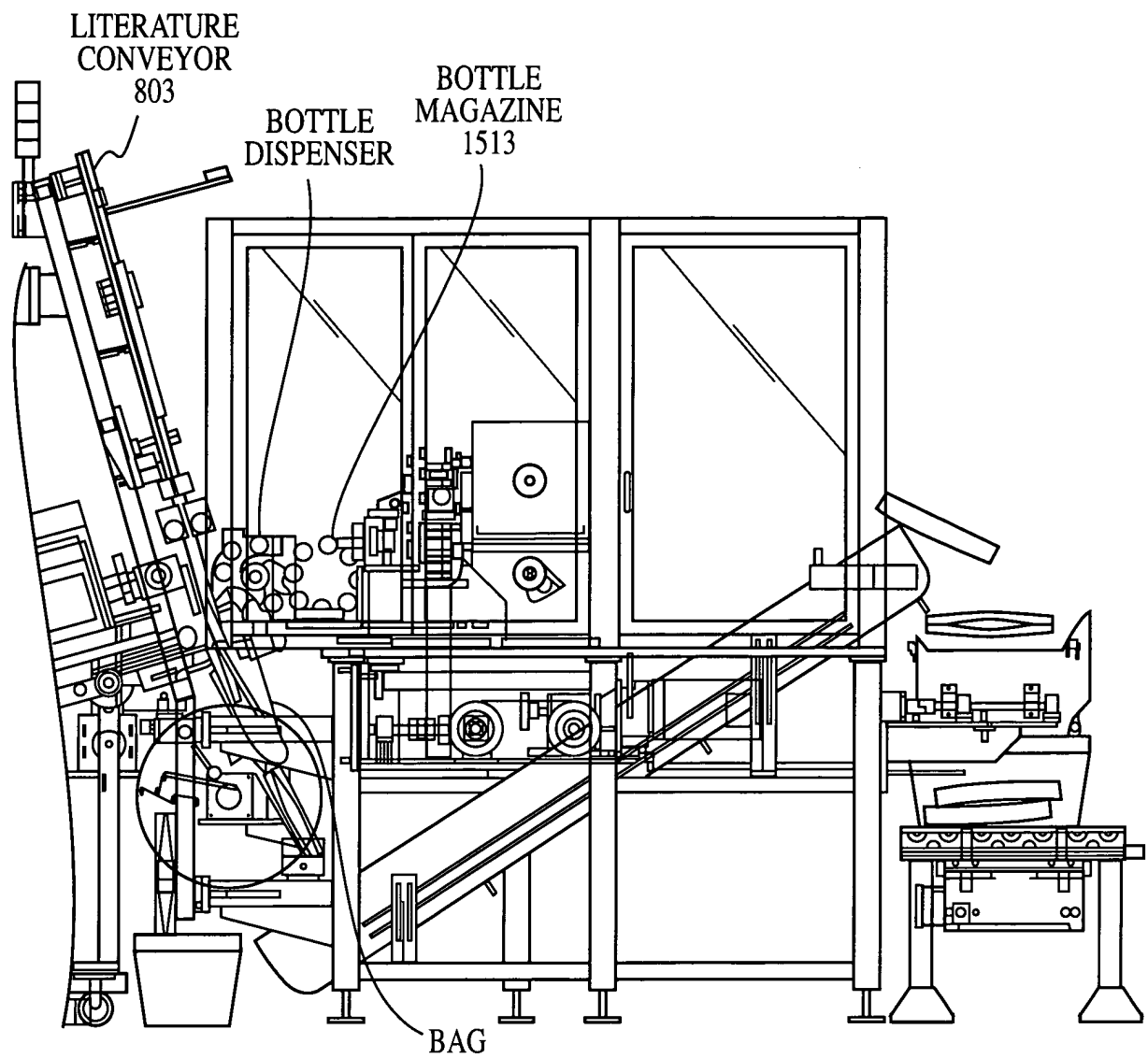


FIG. 15C

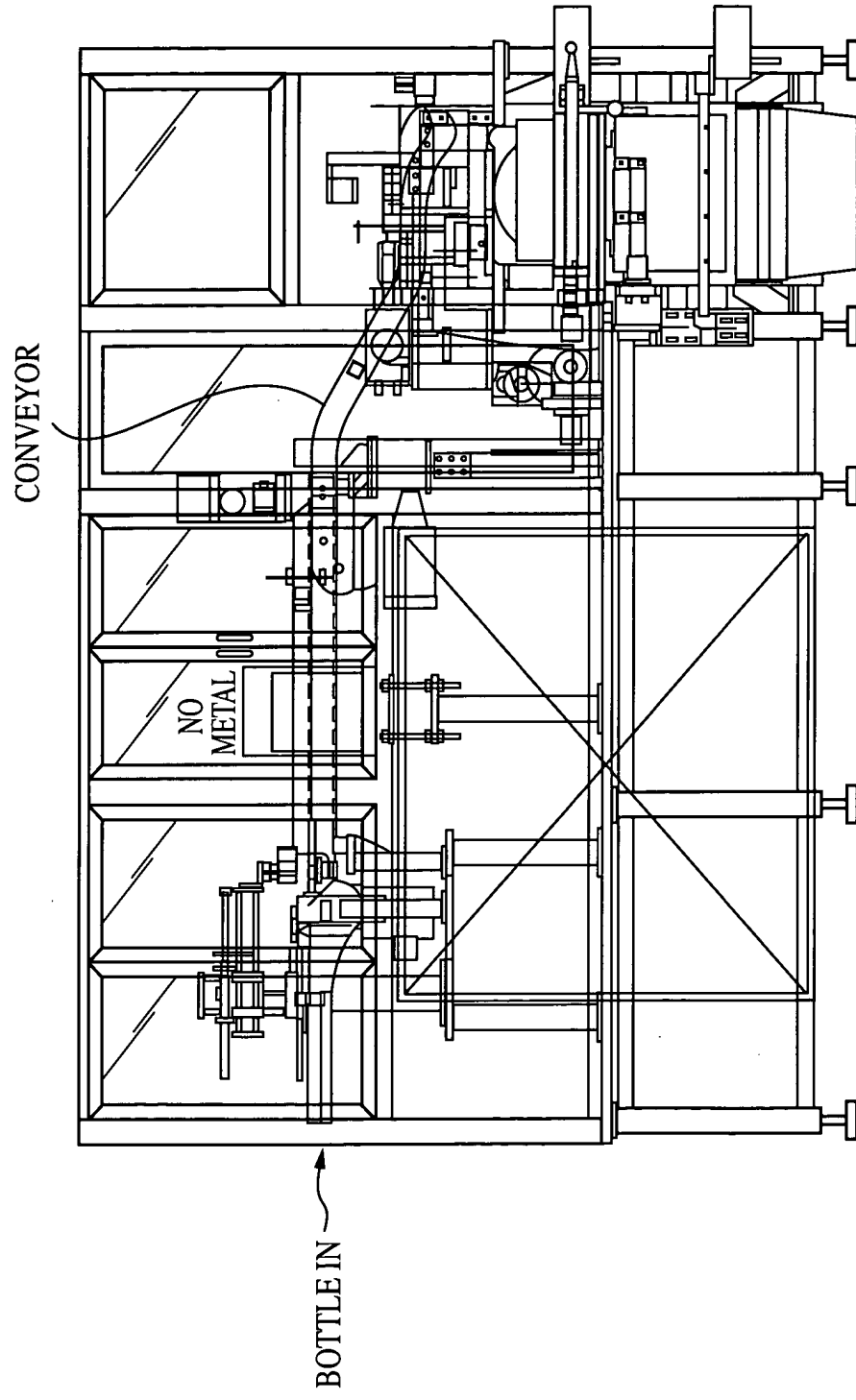


FIG. 15D

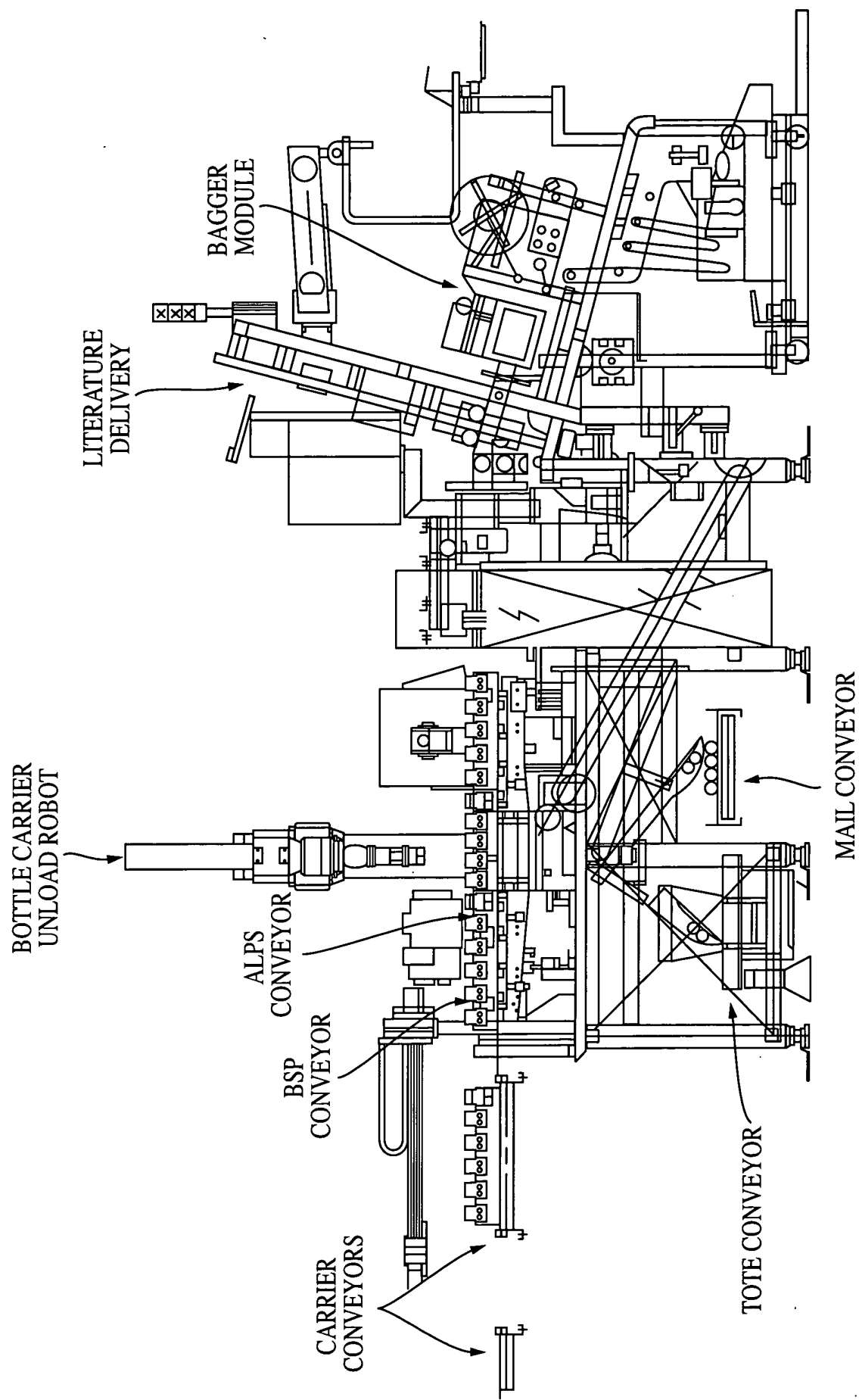


FIG. 15E

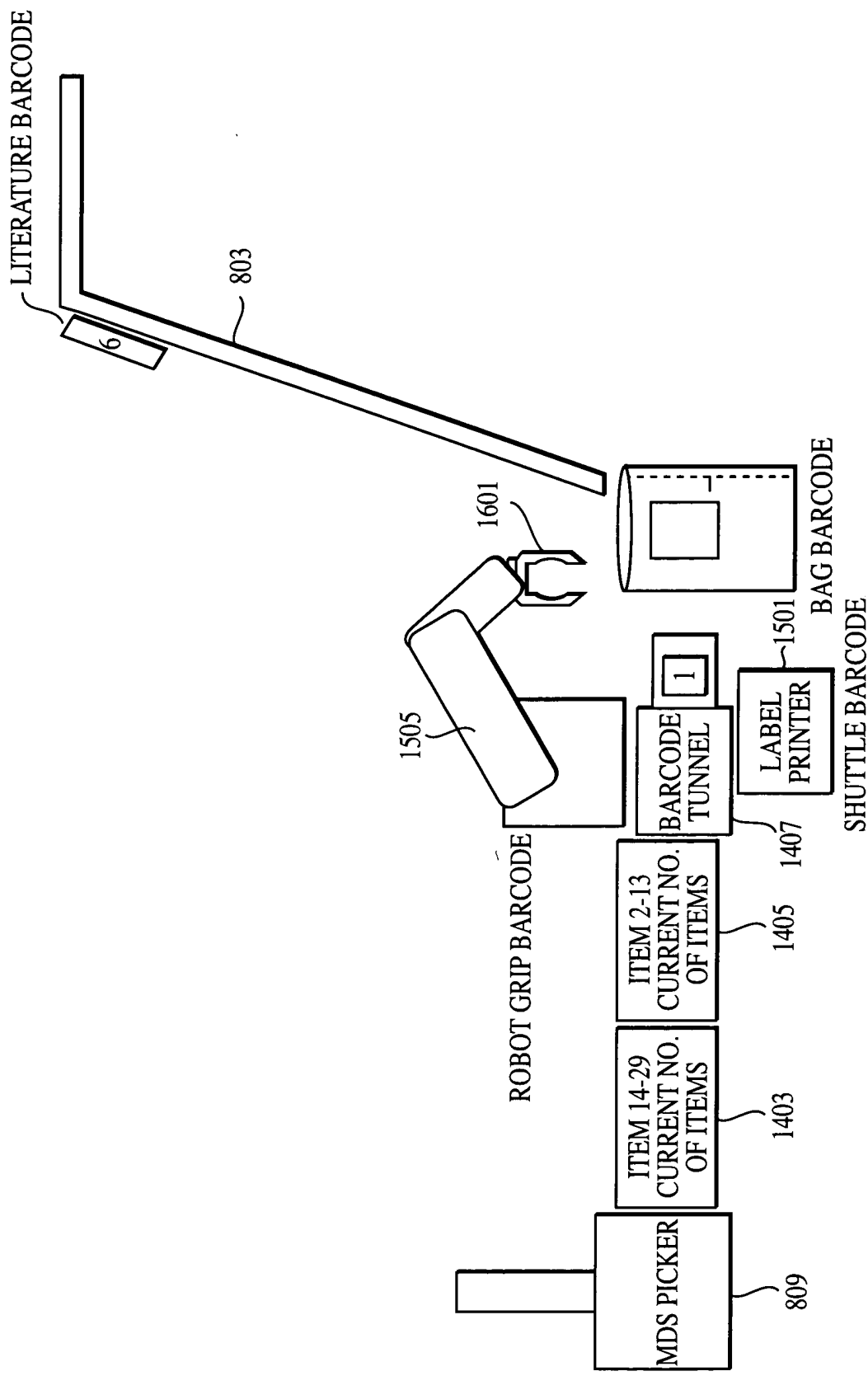


FIG. 16

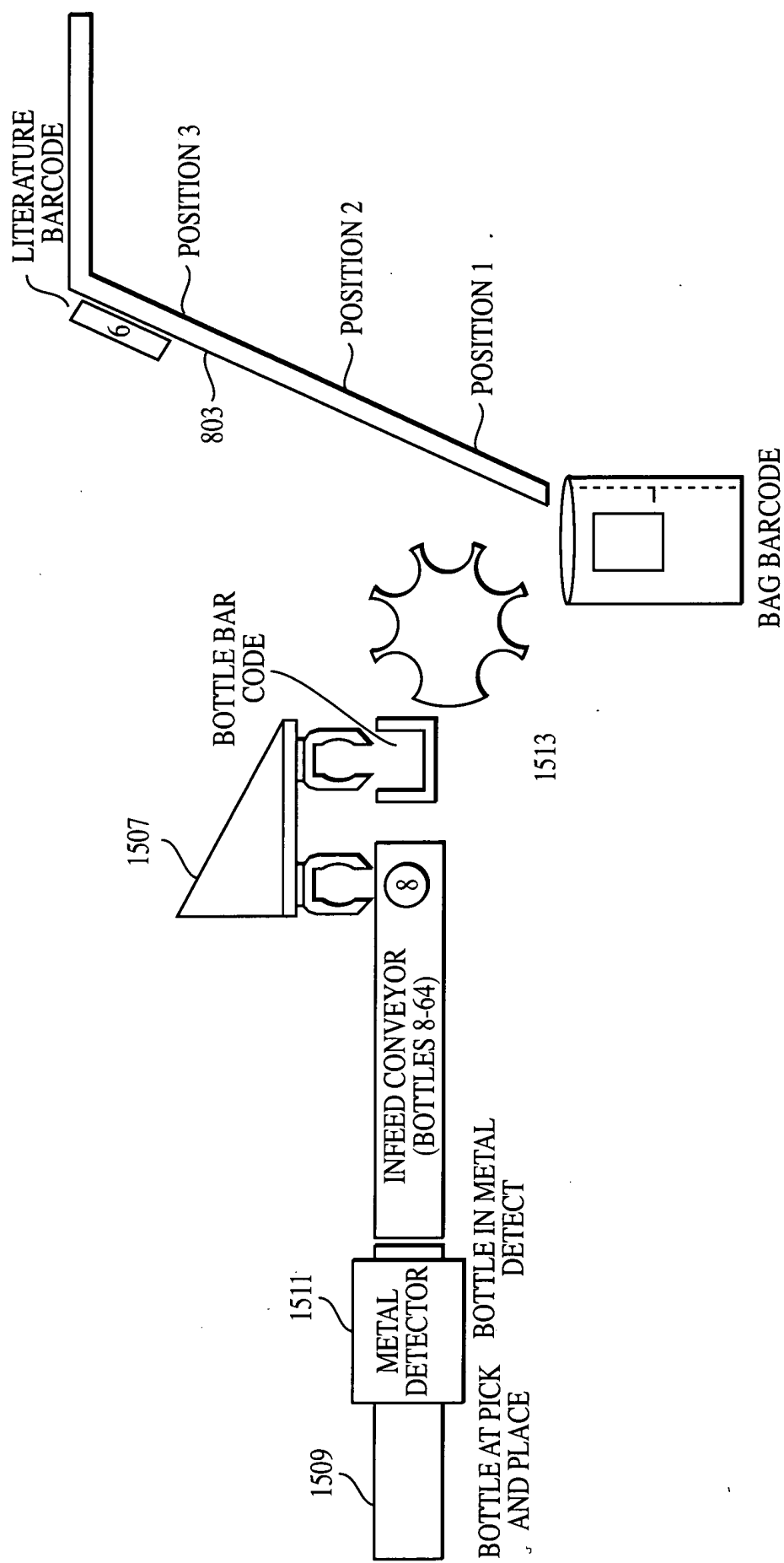


FIG. 17

1801

MERCK-MEDCO RX SERVICES ONE MILLENNIUM DRIVE WILLINGBORO, NJ 08046		PHONE: 1-800-123-4567		DEA#123456789 DATE: 04/19/02	
NAME: JOHN Q. PUBLIC:		DR. Smith		RX: 0123456789 19	
Take one tablet after each meal and one before bedtime.					
Drug Name MFG: MERCK RPHC Wastyle		10mg DISCARD AFTER ic/Publ GENERIC SUBSTITUTION FOR CODINE		Tablet ID NO REFILLS ORDER AFTER 20020715	
CAUTION: DO NOT USE WITH ALCOHOL OR NON PRESCRIBED DRUGS WITHOUT CONSULTING THE PRESCRIBING PRACTITIONER					
		QTY: 90 Bottle 1 of 1			
		COPYRIGHT PHARMEX 2000			
		MAY CAUSE DROWSINESS. ALCOHOL MAY INTENSIFY THIS EFFECT. USE CARE WHEN OPERATING A CAR OR DANGEROUS MACHINERY			
		IMPORTANT! FINISH ALL THIS MEDICATION UNLESS OTHERWISE DIRECTED BY PRESCRIBER			
		TAKE MEDICATION ON AN EMPTY STOMACH 1 HOUR BEFORE OR 2 TO 3 HOUR AFTER A MEAL UNLESS OTHERWISE DIRECTED BY YOUR DOCTOR.			
		DO NOT TAKE DAIRY PRODUCTS, ANTACIDS, OR IRON PREPARATIONS WITHIN ONE HOUR OF THIS MEDICATION.			
		AOC 1 17:42:55			
		John Q. Public		25000018010022	
				Please Open Here To View The Patient Label	



01234567891234

JOHN Q. PUBLICXXXXXXXXXX

Please Open Here
To View The
Patient Label

1803

FIG. 18

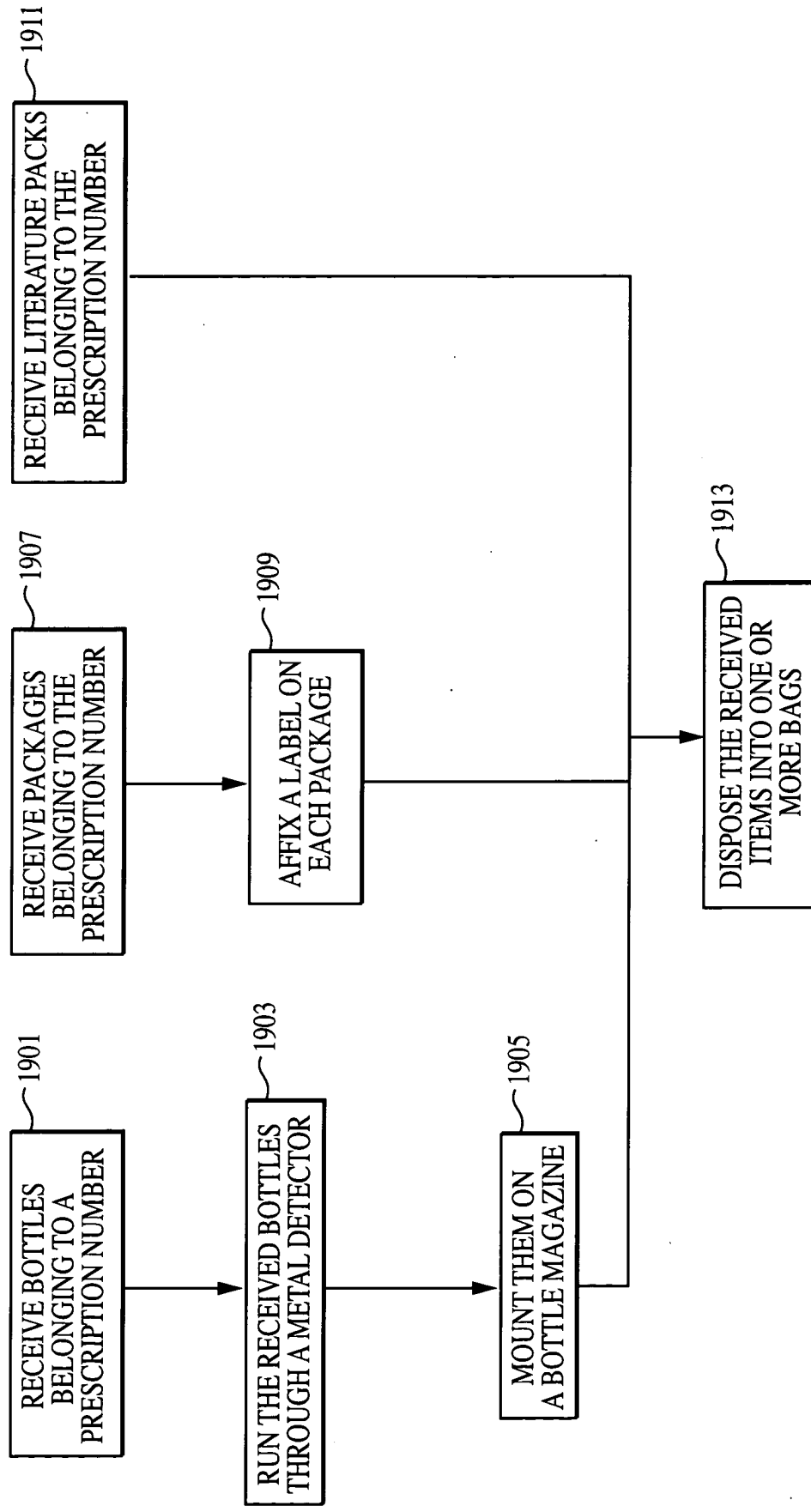
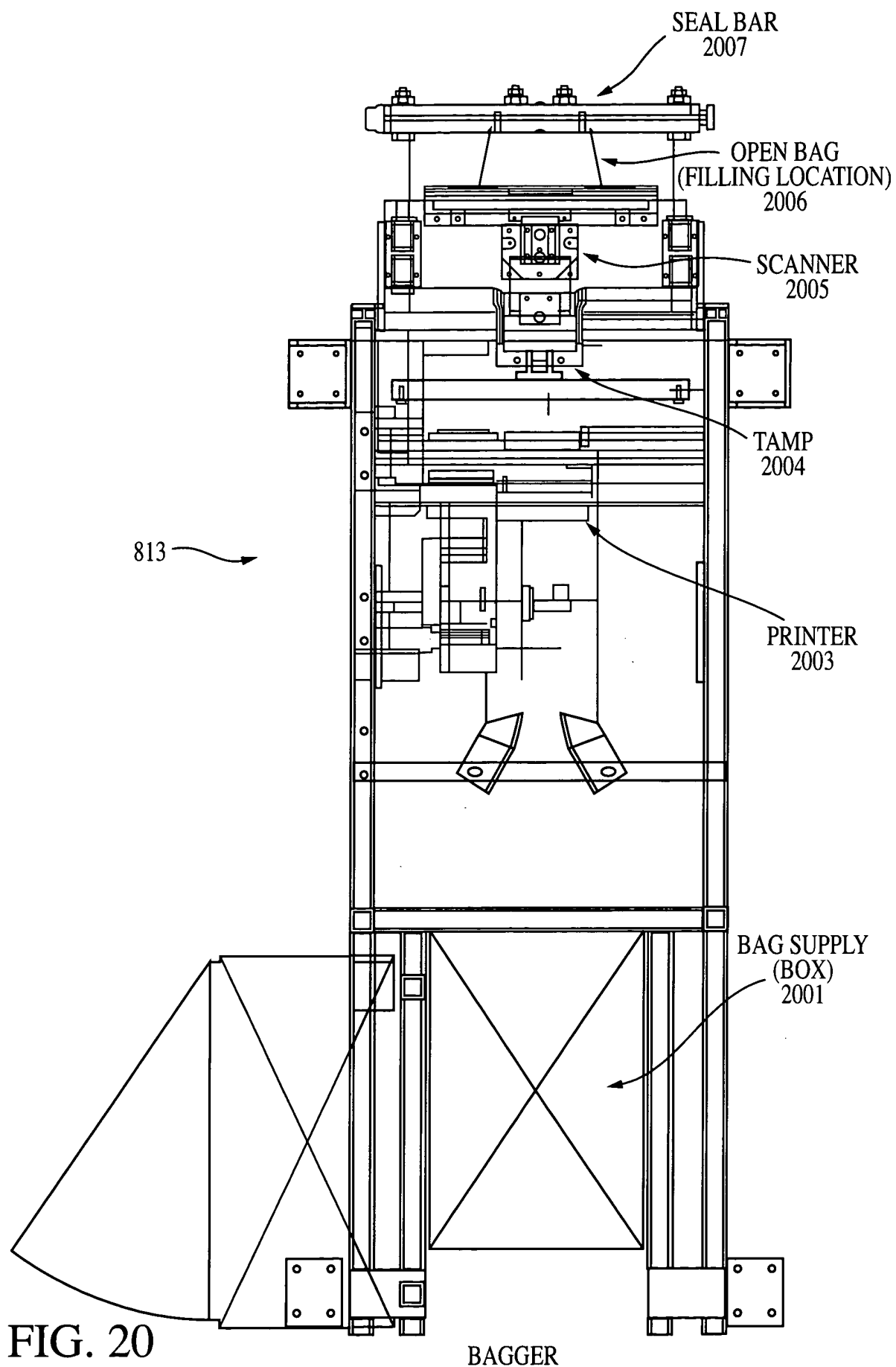


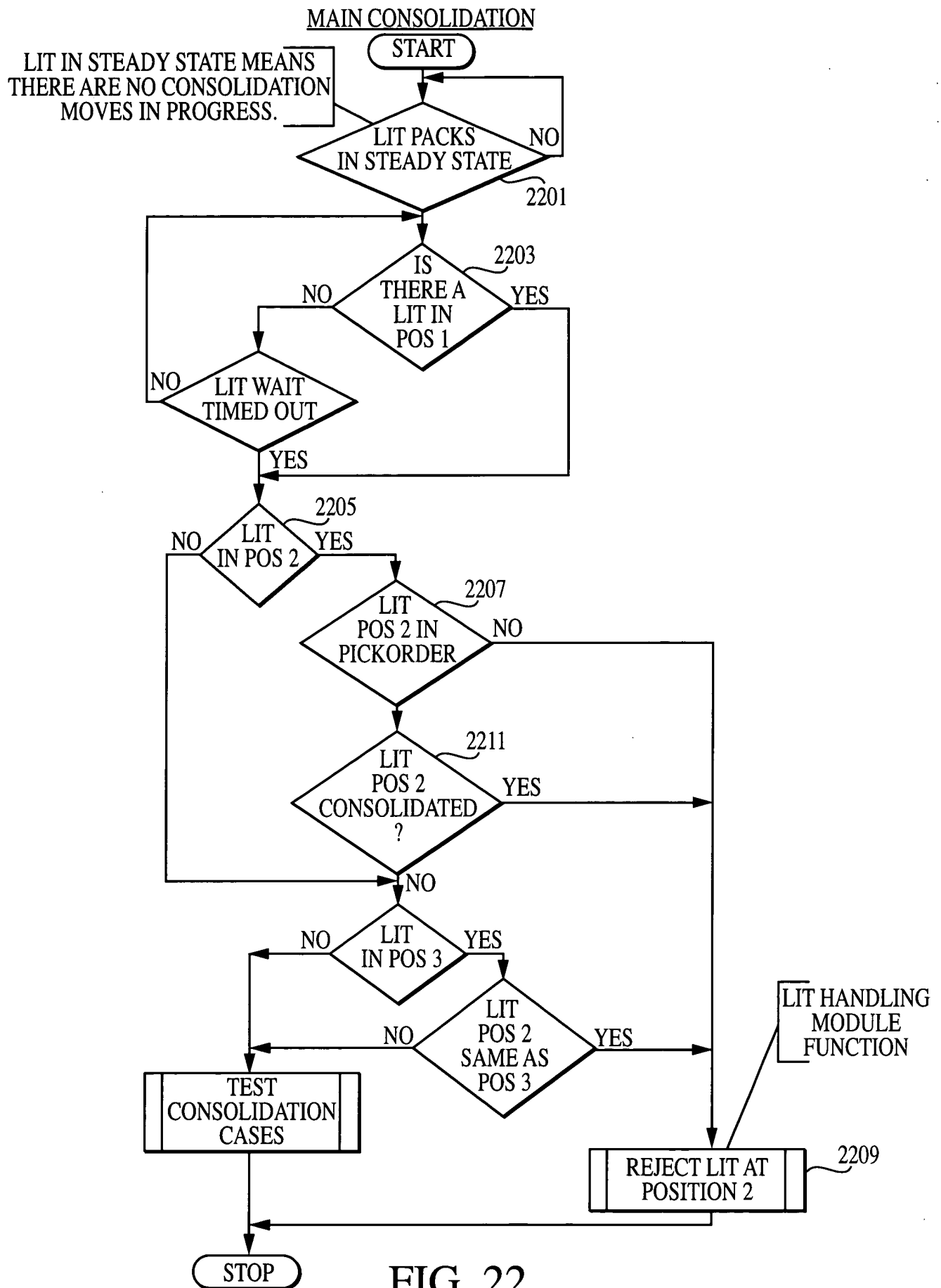
FIG. 19



The diagram illustrates the control system for a pharmaceutical bagging machine, centered around the **CONSOLIDATION LOGIC 2101**. The system components and their interactions are as follows:

- Input/Output Stations:**
 - DISPATCHER/PINCHBELT** and **BOTTLE TABLE/MAGAZINE** provide input to the **CONSOLIDATION LOGIC 2101**.
 - ROBOT 2105** receives control signals from the logic and provides feedback via **PICK CARTON**, **DROP BOTTLES**, and **DROP CARTON TO BAG**.
 - PATIENT LABEL PRINTER 2107** receives **PRINT LABEL** and **REJECT LABEL** signals, providing **LABEL PRINT STATUS** feedback.
 - BAGGER 2109** receives **DESIRED BAG #** and **VALIDATED BAG HANGING** signals, providing **QUEUE BAG #** and **DROP BAG** feedback.
 - MDS PICKER** receives **TRANSFER TO CONVEYOR** and **PICKER STATUS** signals.
- Internal Logic and Control Signals:**
 - CONSOLIDATION LOGIC 2101** is the central processing unit, managing the flow of materials and data.
 - LIT HANDLING 2103** manages **LIT STATUS (1,2,3)**, **LIT 2->3**, **LIT 1->2**, **REJECT LIT**, **LIT 2-> BAG**, **LIT 3-> BAG**, and **LIT 2-> DISC CONV.**.
 - SEAL AND DROP BAG** and **DROP BAG** are part of the bagging process.
 - QUEUE BAG #** and **DESIRED BAG #** are used for bag identification.
 - VALIDATED BAG HANGING** and **TRANSFER TO CONVEYOR** are part of the final output stage.
- System Status and Control:**
 - LIT TIMEOUT** and **LIT AT END OF BELT** are timing and position signals.
 - BOTTLES TO MAGAZINE** and **BOTTLES IN MAG** are inventory signals.
 - APPLY LABEL** and **REJECT LABEL** are control signals for labeling.
 - PICKER ORDER #** and **PICKER STATUS** are signals for the MDS picker.
 - CURRENT BAG #** and **NEXT LIT BATCH FLAG** are batch control signals.
 - PICK/PRINT ORDER GENERATION** is the final output of the system.

FIG. 21



CONSOLIDATION CASE 1:
DROP LIT ONLY TO DISCHARGE CONVEYOR

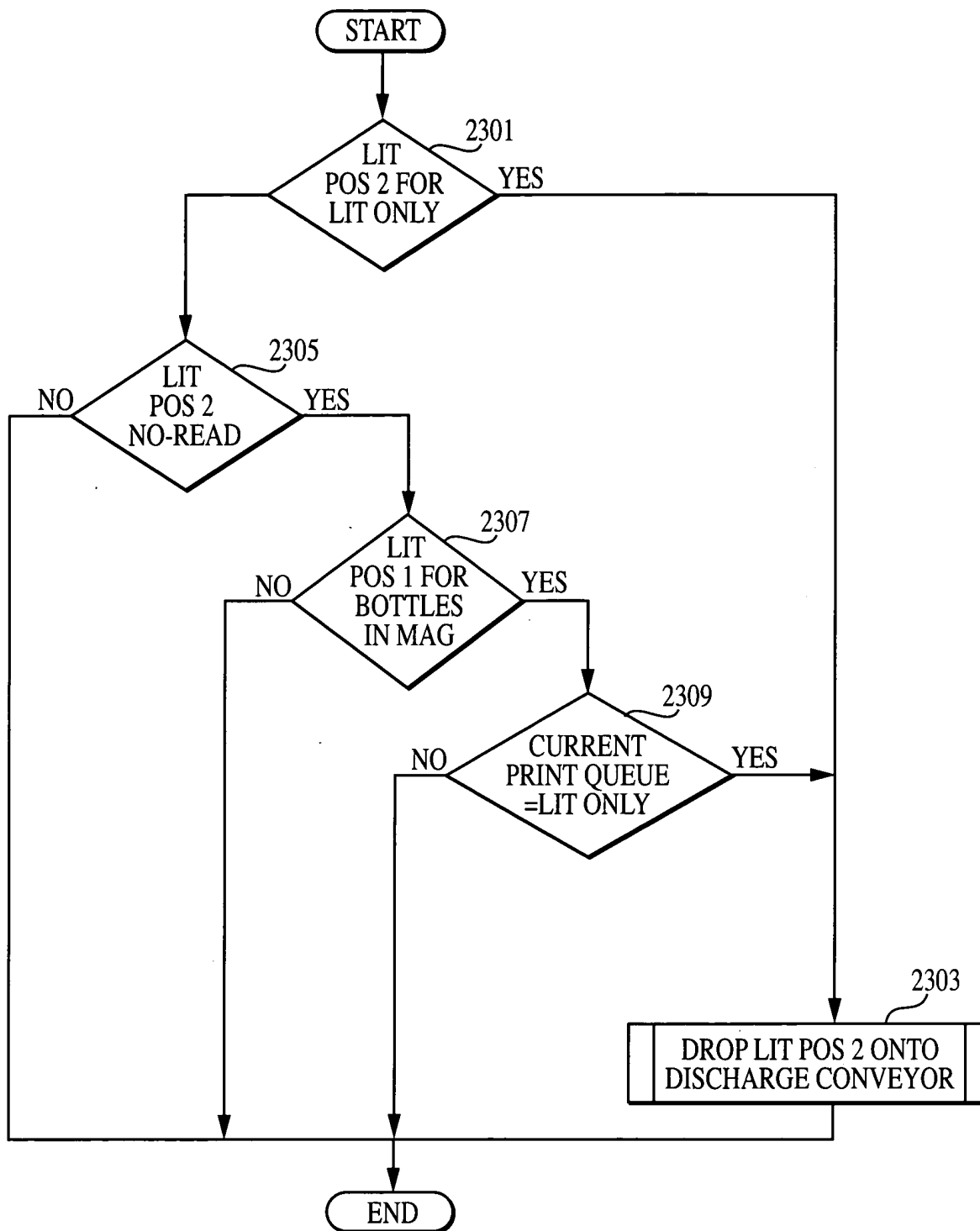


FIG. 23

CONSOLIDATION CASE 2:
DROP LIT POSITION 2 INTO BAG

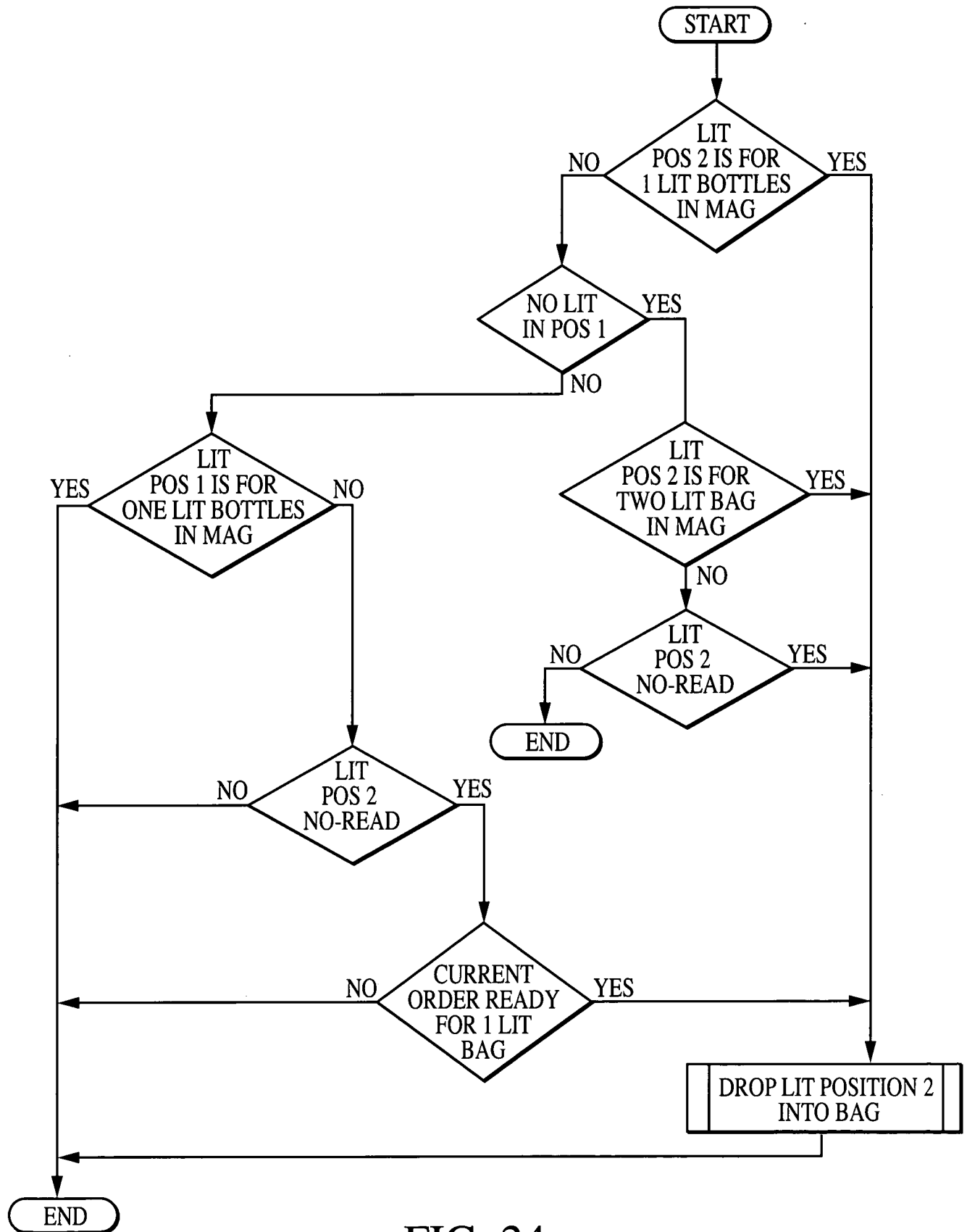


FIG. 24

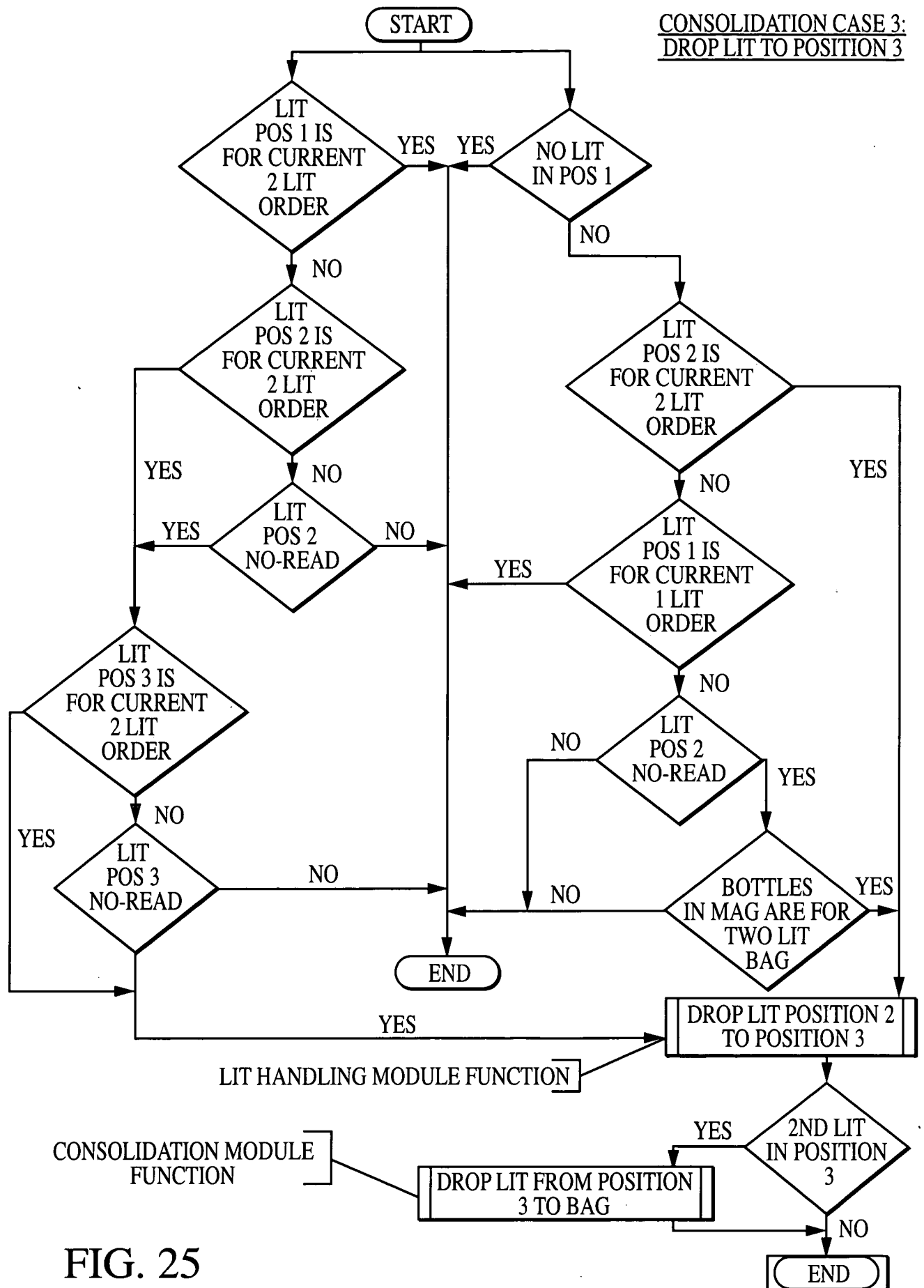
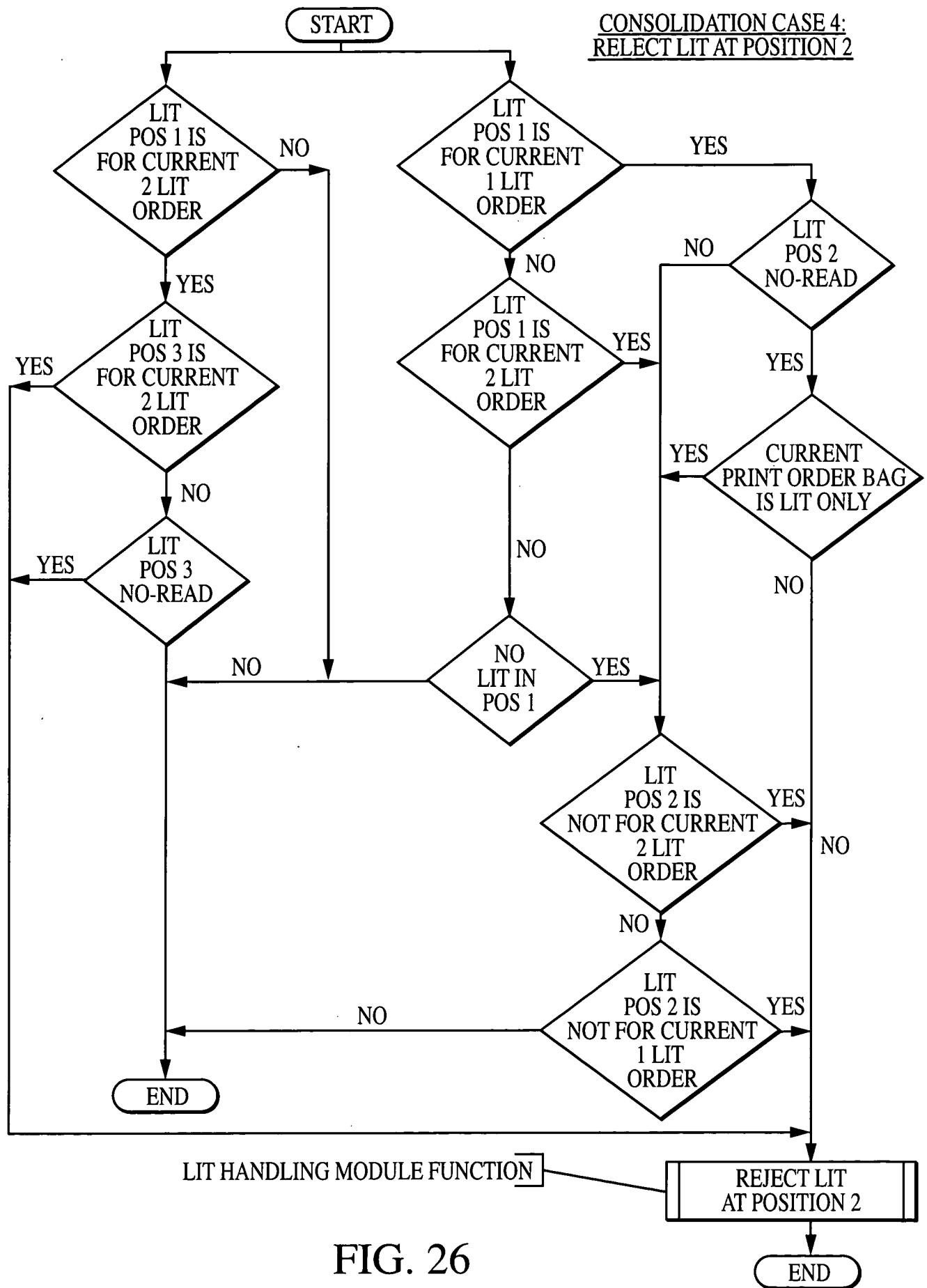


FIG. 25



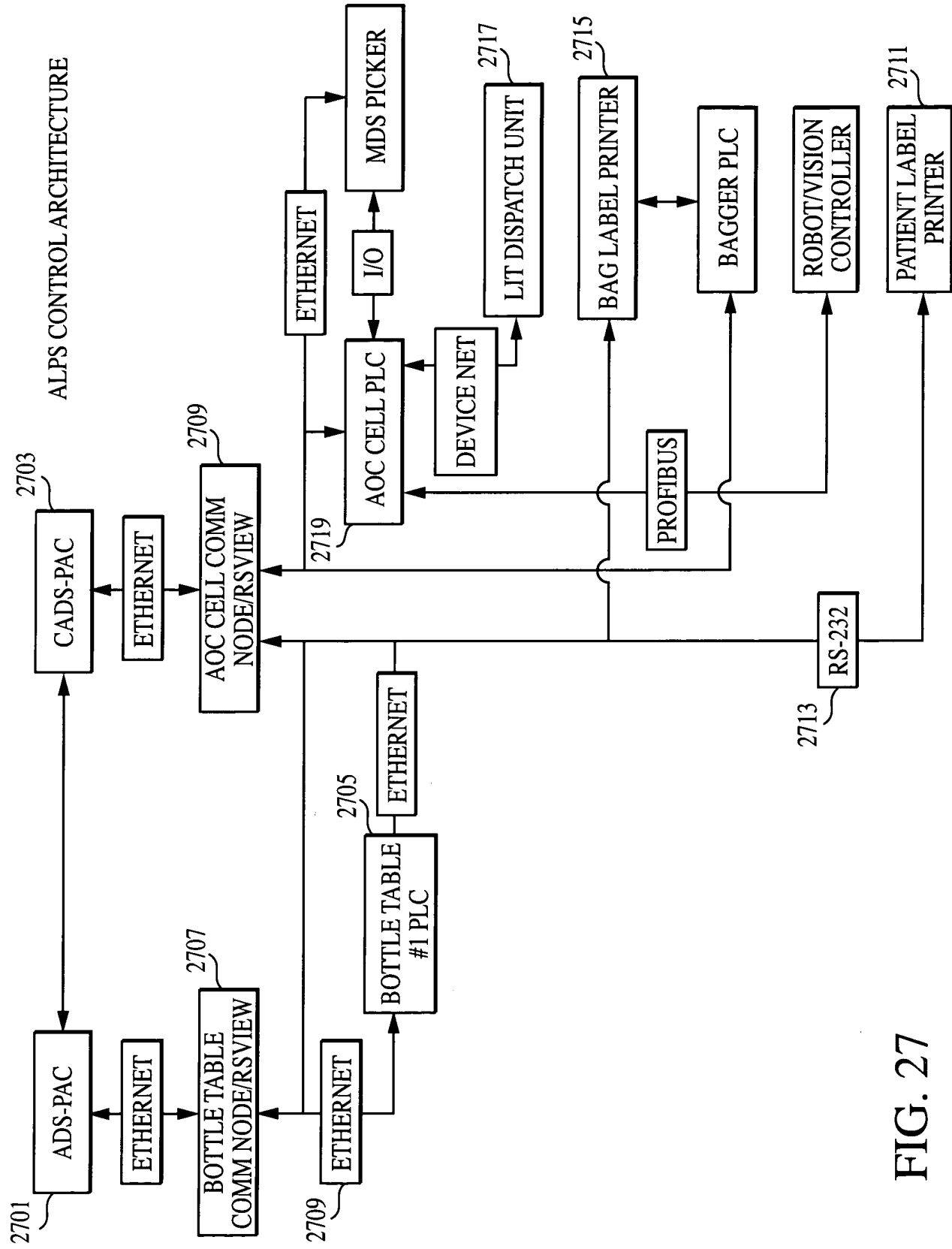
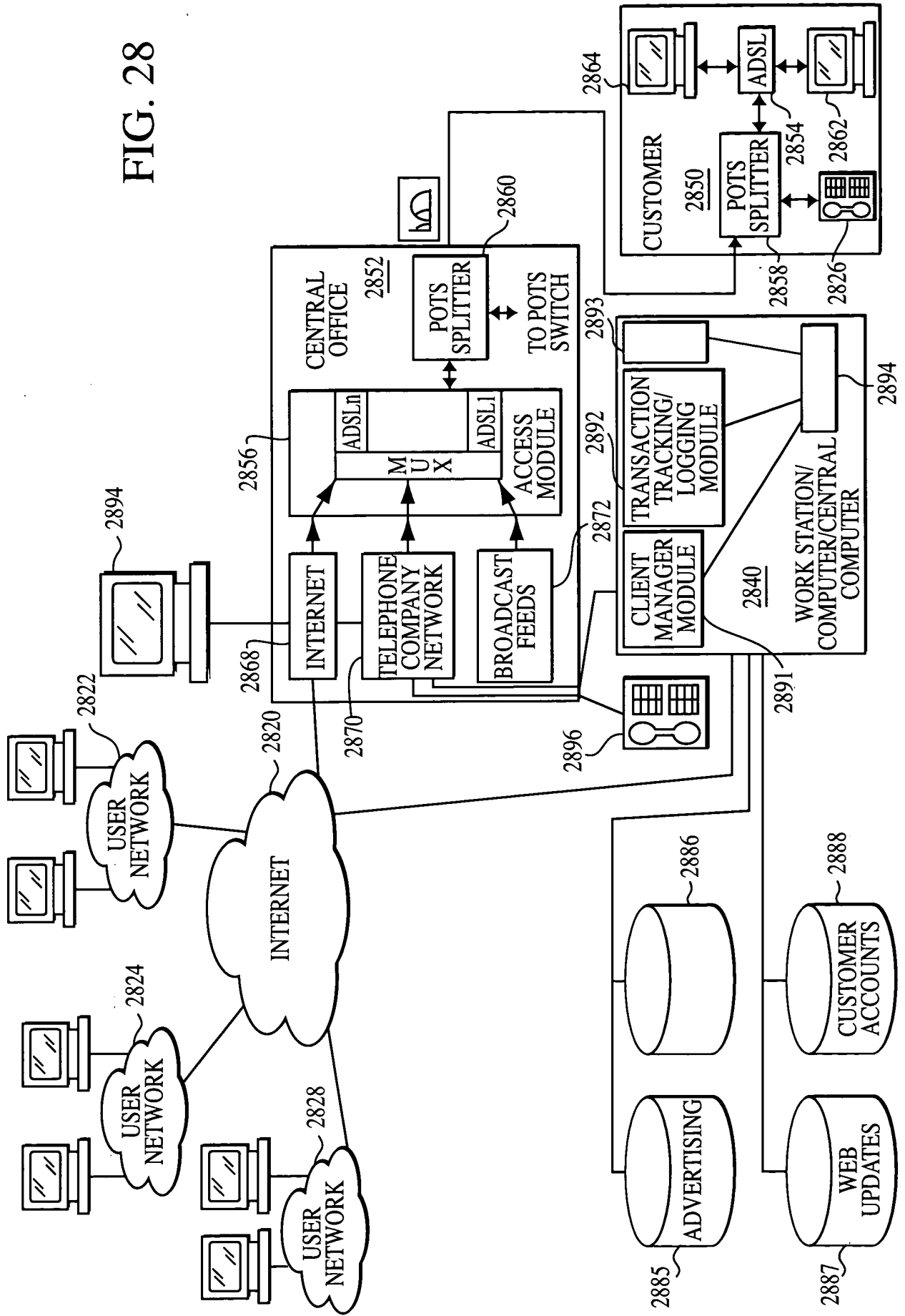


FIG. 27

FIG. 28



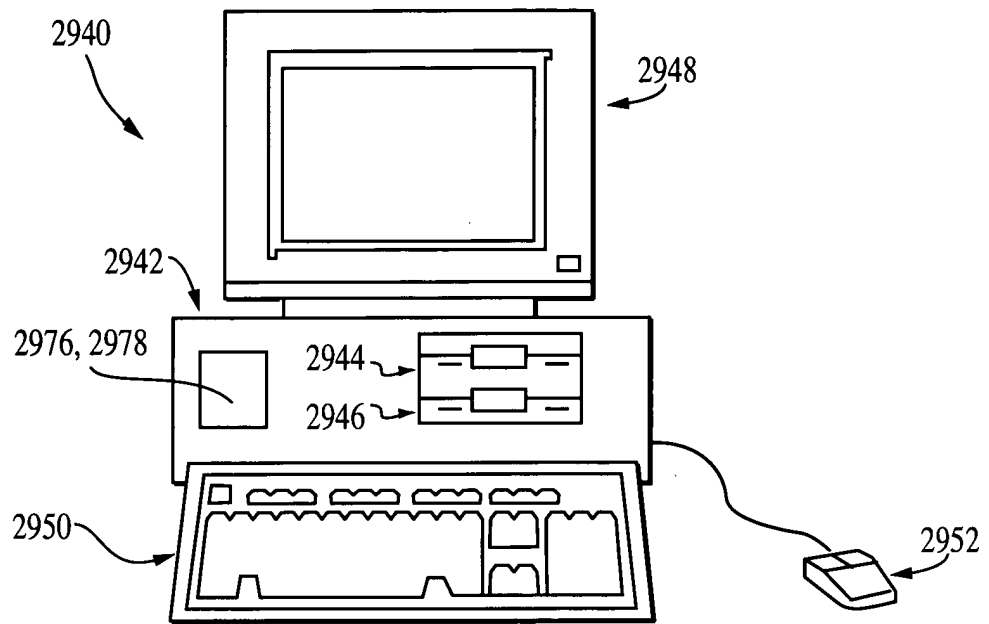


FIG. 29

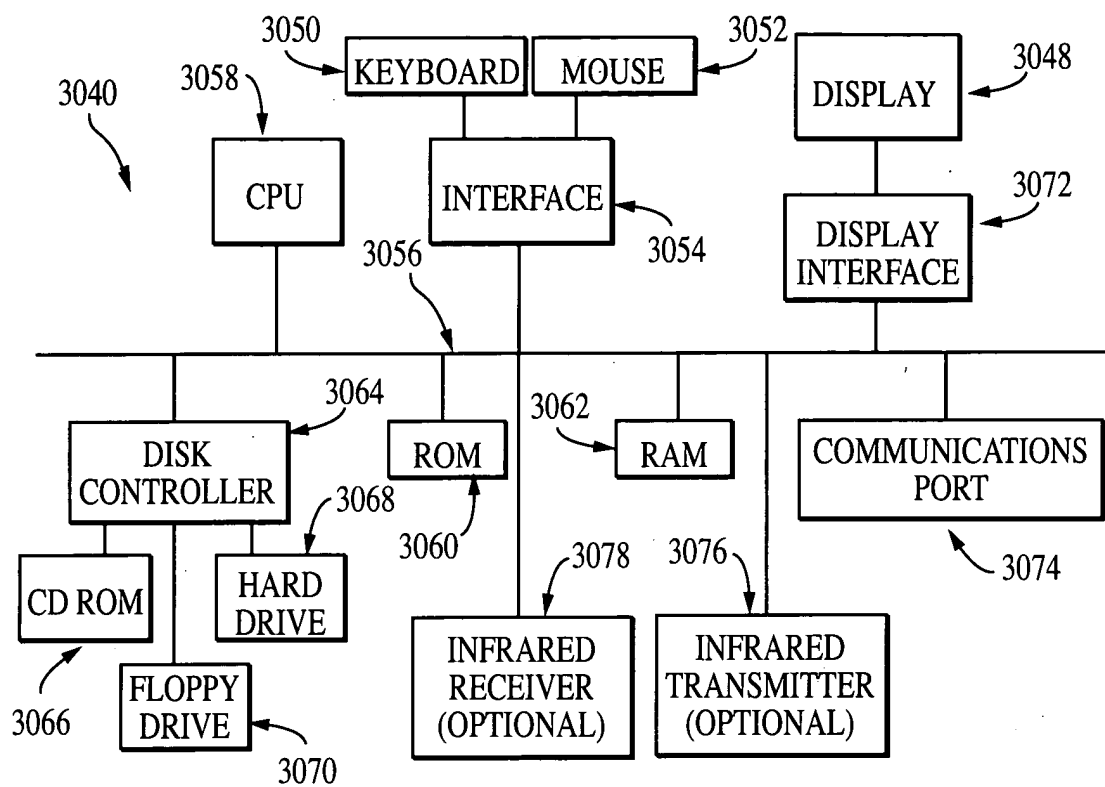


FIG. 30

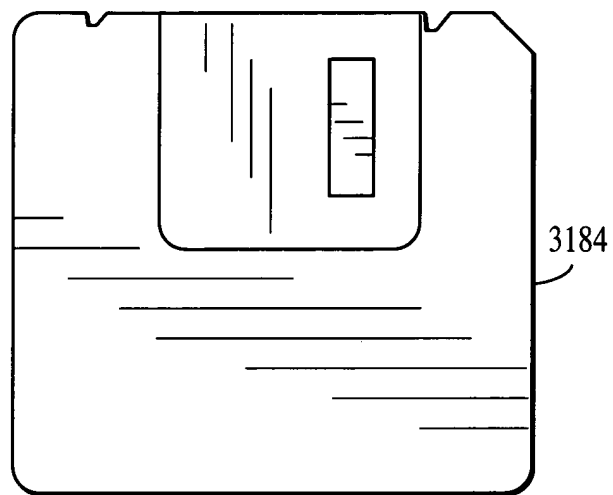


FIG. 31